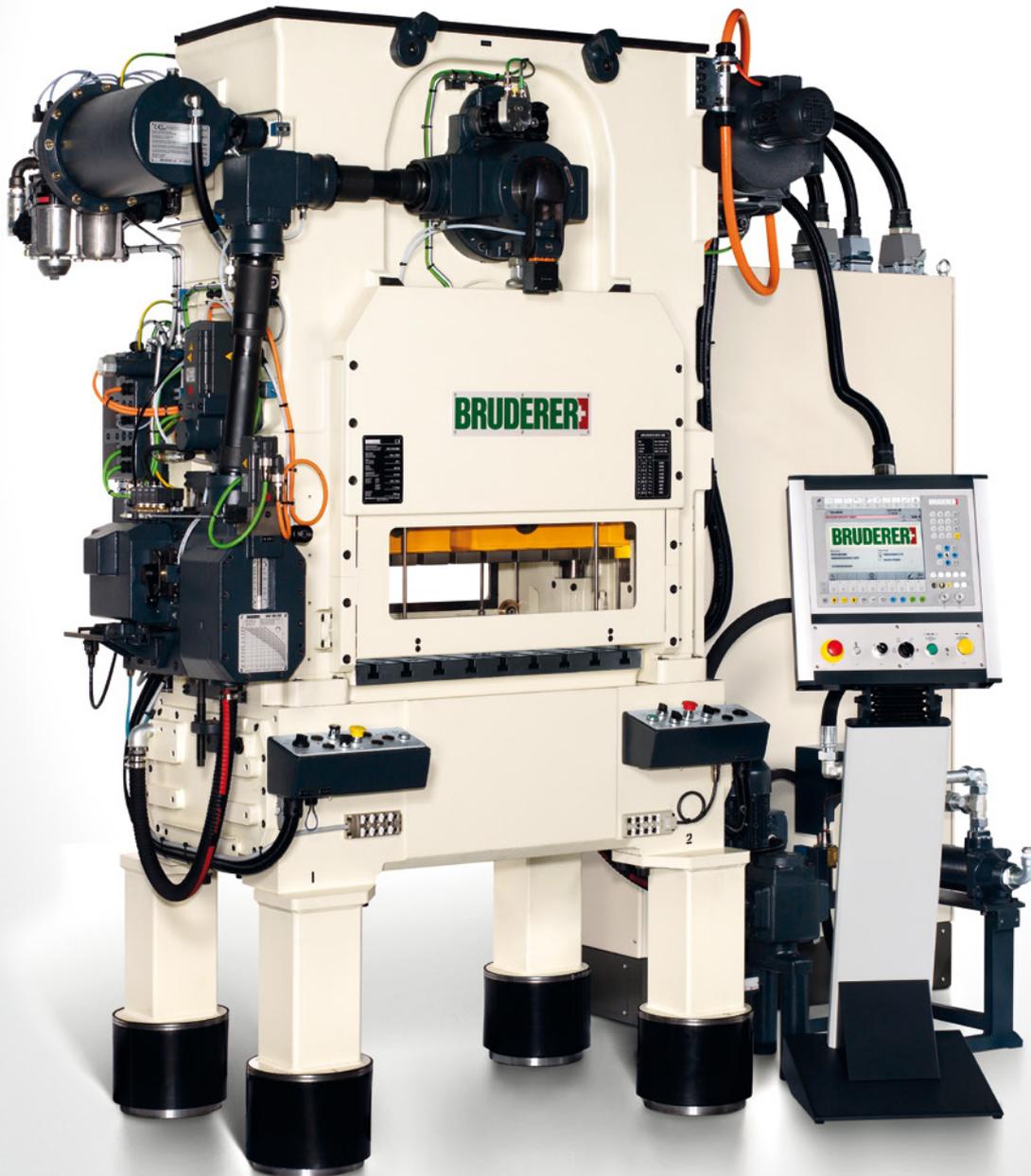


## Planetary Gearbox BPG

**BRUDERER+**

PRECISION – SWISS MADE

# Expand the possibilities of your BSTA.



# The 2 in 1 Solution from BRUDERER – Try Out Press and Fully Automated Stamping Machine.

## Key features:

- Fully automated stamping press and tryout press all in one
- Manual operation for stamping press via hand control wheel
- Allows test runs at full press capacity, even at lowest stroke rate
- Simple correction of ram height via hand control wheel
- Displays relevant values on the hand control (press force, distance from BDC)

## Customer benefits:

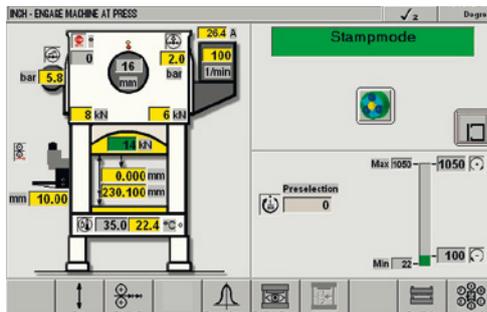
- Test your tools under production conditions
- Control of the stamping press with the manual operation
- Infinite control to maximize set-up and die development
- Better Testing of tools and materials
- No misunderstandings – Development & Production staff use the same machine



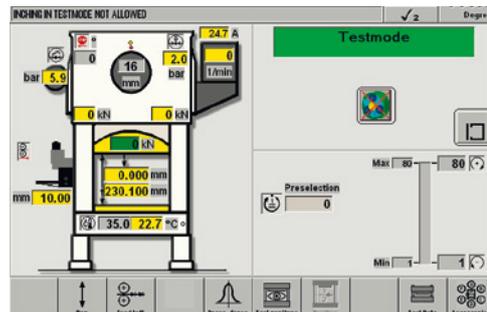
Manual operation.



BPG 22 planetary gearbox.

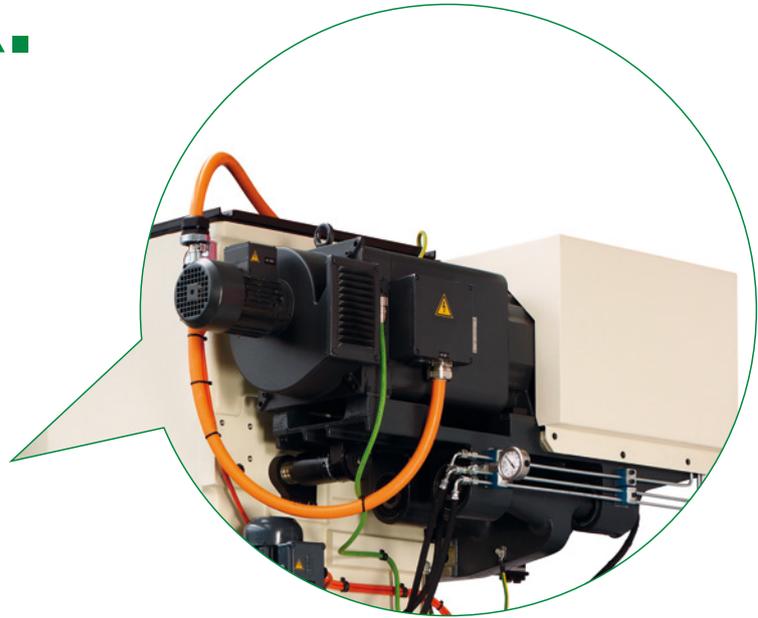


Stampmode.



Testmode.

# Technical data BRUDERER Planetary Gearbox.



With the planetary gear speed is selectable from one stroke per minute. Even with minimal speed you are using 100% power.

Machine	BSTA 280 and BSTA 510	
Operation mode	Planetary gearbox ON	Planetary gearbox OFF
Stroke speed	1 – 80	100 – max. Stroke speed

## The combination of BSTA 510 or BSTA 280 and BPG saves you time and money:



Set-up and fine-tuning, are more precise and more reliable.



No need for re-tooling and subsequent fine-tuning, therefore you save time.



No additional equipment is needed for testing and set-up of tools.

## Competence centres:

### **BRUDERER GMBH**

Kieferstrasse 28, D - 44225 Dortmund  
☎ +49 231 79 20 22-0, 📠 +49 231 71 91 53  
info.de@bruderer.com

### **BRUDERER MACHINERY INC.**

1200 Hendricks Causeway, Ridgefield, NJ 07657, USA  
☎ +1 201 941 2121, 📠 +1 201 886 2010  
info@brudereramericas.com

### **BRUDERER MACHINERY (SUZHOU) CO., LTD.**

No. 485 Suhong Middle Road, Suzhou Industrial Park  
Jiangsu Province, P.R. China 215027  
☎ +86 512 6258 8292, 📠 +86 512 6258 8293  
info.cn@bruderer.com

### **BRUDERER PRESSES (FAR EAST) PTE LTD.**

65 Loyang Way, Singapore 508755  
☎ +65 6546 8121, 📠 +65 6546 8131  
info.sg@bruderer.com

### **BRUDERER PRESSES K.K.**

Yakou 2306-2, Sakae-Machi, Inba-Gun, Chiba-Ken Japan 270-1502  
☎ +81 476 801 788, 📠 +81 476 851 277  
info.jp@bruderer.com

### **BRUDERER UK LTD.**

Cradock Road, GB-Luton, Bedfordshire LU4 0JF  
☎ +44 1582 56 03 00, 📠 +44 1582 57 06 11  
info.uk@bruderer.com

## Sales and service:

### **BRUDERER (DONGGUAN) MACHINERY CO., LTD.**

Unit E1-22, Changrong International Machinery  
Hardware Business Mansion  
ZhenAn Avenue WuSha Road, ChangAn Town  
Dongguan City, P.R. China 523859  
☎ +86 769 8188 8180, 📠 +86 769 8188 7797  
info.bdg@bruderer.com

### **BRUDERER IBERICA, S.L.**

Pol. Ind. Magarola Sud, C/. Cerámica 5 - Nave B-1  
E-08292 Esparraguera (Barcelona)  
☎ +34 93 770 84 60, 📠 +34 93 779 51 15  
info.es@bruderer.com

### **BRUDERER PRESSES FRANCE S.A.R.L.**

Z.I. du Petit Parc, F - 78920 Ecquevilly  
☎ +33 1 34 75 00 40, 📠 +33 1 34 75 52 36  
info.fr@bruderer.com

### **BRUDERER PRESSES INDIA PVT LTD.**

2, Chandragupta Estate, Ground Floor, Andheri Link Road  
Near Monginis Andheri West, Mumbai 400 053, India  
☎ +91 22 6695 1945/46, 📠 +91 22 6695 1948  
info.in@bruderer.com

## Distribution Partners:

See [www.brunderer.com](http://www.brunderer.com)

### **BRUDERER AG**

Egnacherstrasse 44, CH-9320 Frasnacht, Switzerland  
☎ +41 71 447 75 00, 📠 +41 71 447 77 80

For more information about BRUDERER and our products,  
services and subsidiaries, visit [www.brunderer.com](http://www.brunderer.com)

**BRUDERER** 

PRECISION – SWISS MADE

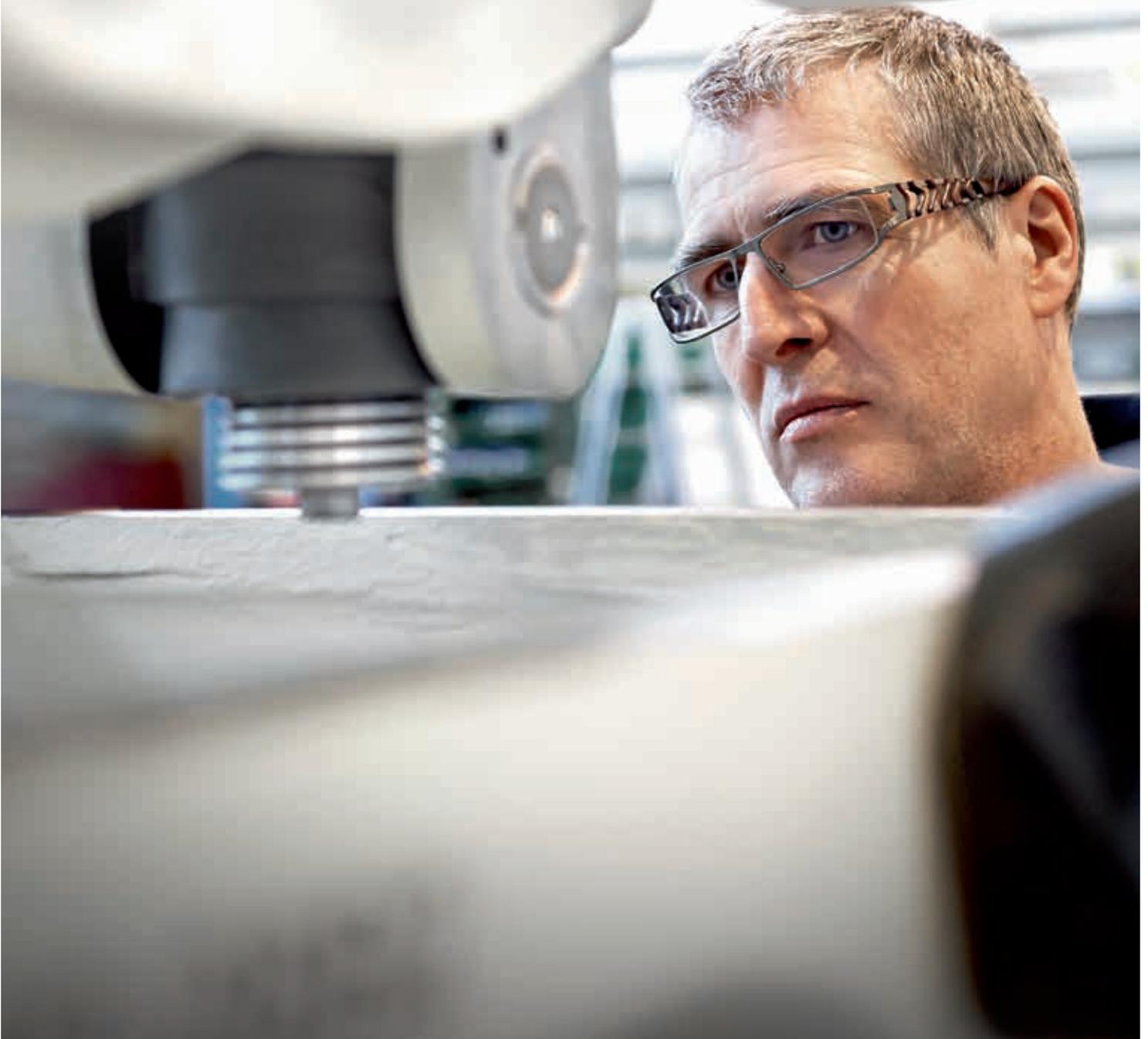
150806\_Korr. Geism

**BSTA 200**

**BRUDERER** 

PRECISION – SWISS MADE

**Precision mechanics  
for universal  
applications.**





# Our experience – for your benefit.

Every BSTA stamping press contains decades of experience that we have built up, in responding to the demands of ambitious customers.

Important innovations and solutions which pay attention to the little details are designed to help you produce more efficiently using our machines. Try them out for yourself.

## The advantages of the BSTA 200 at a glance.

### **Adjustable stroke with mass balancing system together with latest control technology:**

- for a multitude of applications
- for a wide variety of stroke heights

### **Thermoneutral ram-guiding system with tilting point control at strip level:**

- for long tool life
- for optimum part quality

### **Ram adjustment during operation under production conditions:**

- for an optimized tool set-up

### **Powerful clutch and brake unit**

- for improved first and last strikes and therefore reduced waste

### **Micro-tolerances maintained in the bottom dead center (BDC):**

- for increased process stability

### **Precision engineering and the unique BRUDERER drive and lever system:**

- for improved reliability and durability across the whole mechanical system

### **Integrated measuring and monitoring function:**

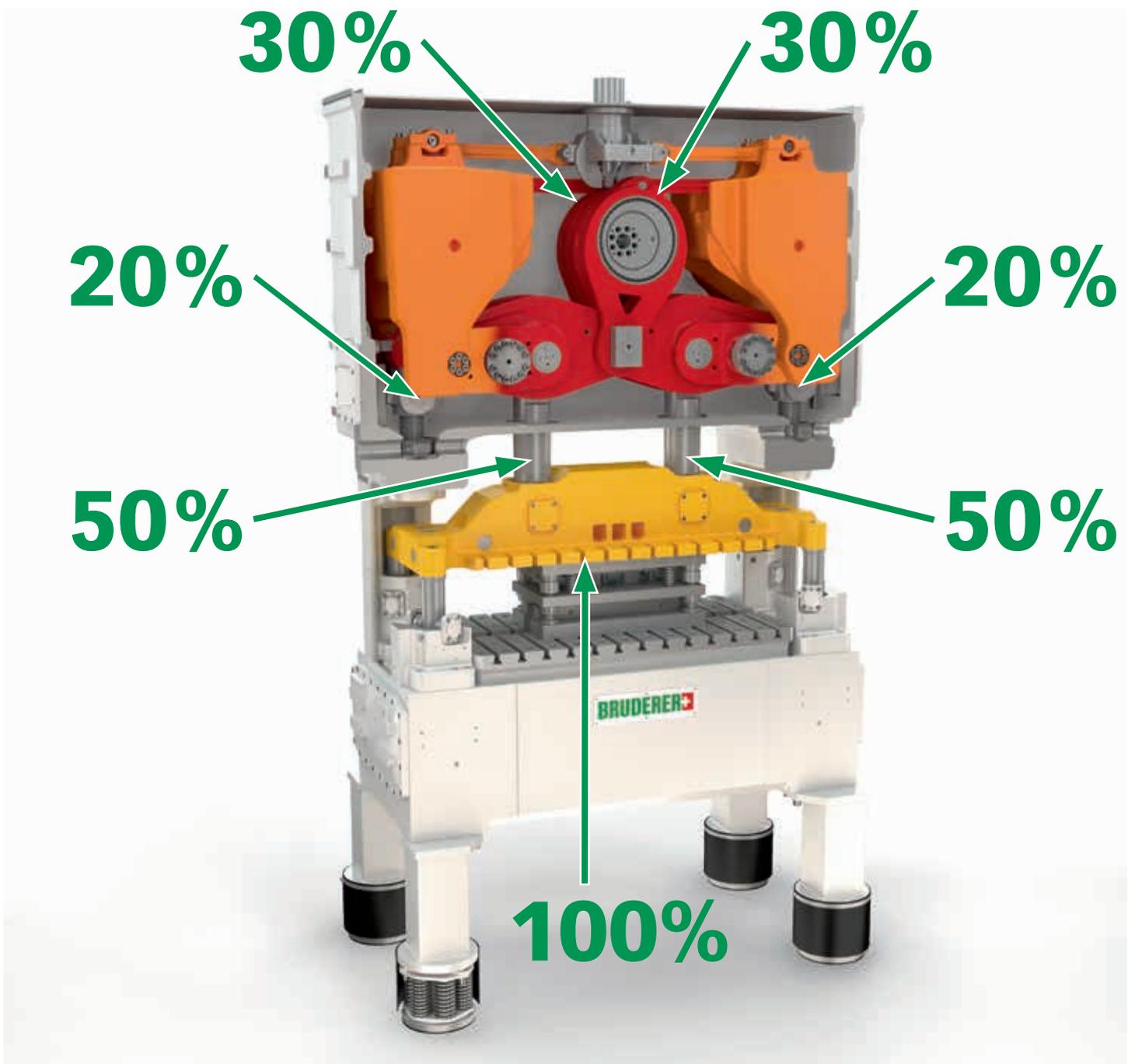
- improved process optimisation by means of simple control system usability

### **Easy attachment of peripheral devices:**

- for quicker integration and maximum productivity

# Power put to work in the right place.

Thanks to the unique lever system of the BSTA stamping press, the load acting on the ram is distributed across the system. This load distribution, together with the absolute minimum clearance and the efficient lubrication system, is a crucial factor in the high durability and consistent precision of the machine.



# Making sure you can produce quicker, for longer and with more precision.

## Regular stamping processes.

Thanks to the unique lever system, the hardened ground ram adjustment spindles only take up 20% of the total load each. This construction makes it possible to adjust the ram height during stamping and to maintain the BDC to the closest of tolerances throughout.

## Longer tool life thanks to good guidance.

To prevent deflection of the punches when running the press with eccentric loads, the ram guide elements are placed exclusively on the same level as the strip. The guide bearings ensure that the thermal influences acting on the ram guides are compensated for, which in turn increase tool life.

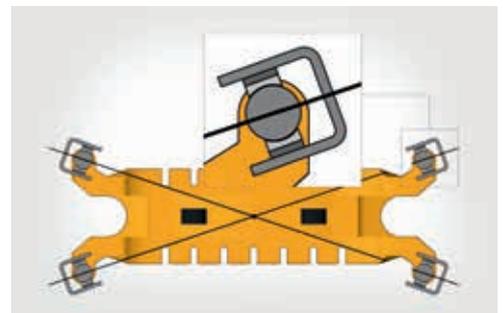
## More flexibility thanks to the right setting.

The quicker stroke change enables different stroke height settings to be set quickly and safely, thus ensuring high levels of flexibility and a wide variety of implementations.

The feed timing of the strip feeder is thus synchronised without additional procedures



Ram adjustment during operation under production conditions.



Thermoneutral ram-guiding to compensate for horizontal expansion due to fluctuations in temperature.



Quicker stroke change for more flexibility.

# Proven solutions.

Leading companies around the world have come to rely on the advantages that BRUDERER fully-automated stamping presses can provide, implementing their manufacturing expertise with our machines to make high-precision parts for products that have become indispensable in our everyday lives.

Wherever the ultimate in availability and precision is required at high and low stroke rates, BRUDERER is there to provide what is needed – for suppliers in the automotive industry, for the manufacturing of connectors for the electronics, electrical engineering and computer industries, for parts for watches and metal packaging for the food industry, to cite just a few examples.

This is how we support our customers, with our expertise and the added precision that our stamping presses provide when it comes to manufacturing quality products.



# Technical data

## BSTA 200.

			BSTA 200 - 60	BSTA 200 - 70
Press force		kN	200	200
Tool loading area	L - R	mm	600	700
Speed	Min.	spm	100	100
- Adjustable stroke machine (standard) <sup>1)</sup>	Max.	spm	1800	1800
- Fixed stroke machine <sup>2)</sup>	Max.	spm	2000	2000
Mains voltage (EN 60204) <sup>A)</sup>		V	400	400
Mains frequency (EN 60204) <sup>A)</sup>		Hz	50 / 60	50 / 60
Connected load <sup>B)</sup>	Max.	kVA	29	29
Control voltage		VDC	24	24
Drive power of main motor		kW	15	15
Compressed air connection R 1/2"	Min. Max.	bar bar	6 10	6 10
Adjustable stroke (standard)		mm mm	8 / 13 / 16 / 19 / 25 / 32 / 38	8 / 13 / 16 / 19 / 25 / 32 / 38
Fixed stroke <sup>A)</sup>	Max.	mm	44	44
Ram adjustment range		mm	40	40
Shut height <sup>A)</sup> (according to stroke)	Min. Max.	mm mm	181 236	181 236
Bolster area	L - R F - B Height <sup>C)</sup>	mm mm mm	590 426 1100	690 426 1100
Ram area	L - R F - B	mm mm	590 270	690 270
Strip inlet height <sup>A)</sup>	Min. Max.	mm mm	50 120	50 120
Strip inlet width (machine)	Max.	mm	190	190
Base plate opening	L - R F - B	mm mm	540 160	640 160
<b>Dimensions</b>				
Press (standard BBV)	L - R	mm	1700	1790
- With manual stroke adjustment	F - B Height Weight (app.)	mm mm kg	915 2460 3300	915 2460 3500
<b>Strip feed unit</b>				
	Standard Variations	BBV 180 BSV 75 BSV 170 BZV 61		

<sup>A)</sup> Options on request. <sup>B)</sup> Incl. standard sockets for peripheral equipment. <sup>C)</sup> Above floor level.

<sup>1)</sup> Adjustable stroke machine with 2000 spm available as option. <sup>2)</sup> Fixed stroke machine with 8 mm shut height. Subject to change.

## Competence centres:

### **BRUDERER GMBH**

Kieferstrasse 28, D - 44225 Dortmund  
☎ +49 231 79 20 22-0, 📠 +49 231 71 91 53  
info.de@bruderer.com

### **BRUDERER MACHINERY INC.**

1200 Hendricks Causeway, Ridgefield, NJ 07657, USA  
☎ +1 201 941 2121, 📠 +1 201 886 2010  
info@brudereramericas.com

### **BRUDERER MACHINERY (SUZHOU) CO., LTD.**

No. 485 Suhong Middle Road, Suzhou Industrial Park  
Jiangsu Province, P.R. China 215027  
☎ +86 512 6258 8292, 📠 +86 512 6258 8293  
info.cn@bruderer.com

### **BRUDERER PRESSES (FAR EAST) PTE LTD.**

65 Loyang Way, Singapore 508755  
☎ +65 6546 8121, 📠 +65 6546 8131  
info.sg@bruderer.com

### **BRUDERER PRESSES K.K.**

Yakou 2306-2, Sakae-Machi, Inba-Gun, Chiba-Ken Japan 270-1502  
☎ +81 476 801 788, 📠 +81 476 851 277  
info.jp@bruderer.com

### **BRUDERER UK LTD.**

Cradock Road, GB-Luton, Bedfordshire LU4 0JF  
☎ +44 1582 56 03 00, 📠 +44 1582 57 06 11  
info.uk@bruderer.com

## Sales and service:

### **BRUDERER (DONGGUAN) MACHINERY CO., LTD.**

Unit E1-22, Changrong International Machinery  
Hardware Business Mansion  
ZhenAn Avenue WuSha Road, ChangAn Town  
Dongguan City, P.R. China 523859  
☎ +86 769 8188 8180, 📠 +86 769 8188 7797  
info.bdg@bruderer.com

### **BRUDERER IBERICA, S.L.**

Pol. Ind. Magarola Sud, C/. Cerámica 5 - Nave B-1  
E-08292 Esparraguera (Barcelona)  
☎ +34 93 770 84 60, 📠 +34 93 779 51 15  
info.es@bruderer.com

### **BRUDERER PRESSES FRANCE S.A.R.L.**

Z.I. du Petit Parc, F - 78920 Ecquevilly  
☎ +33 1 34 75 00 40, 📠 +33 1 34 75 52 36  
info.fr@bruderer.com

### **BRUDERER PRESSES INDIA PVT LTD.**

2, Chandragupta Estate, Ground Floor, Andheri Link Road  
Near Monginis Andheri West, Mumbai 400 053, India  
☎ +91 22 6695 1945/46, 📠 +91 22 6695 1948  
info.in@bruderer.com

## Distribution Partners:

See [www.brunderer.com](http://www.brunderer.com)

### **BRUDERER AG**

Egnacherstrasse 44, CH-9320 Frasnacht, Switzerland  
☎ +41 71 447 75 00, 📠 +41 71 447 77 80

For more information about BRUDERER and our products,  
services and subsidiaries, visit [www.brunderer.com](http://www.brunderer.com)

**BRUDERER** 

PRECISION – SWISS MADE

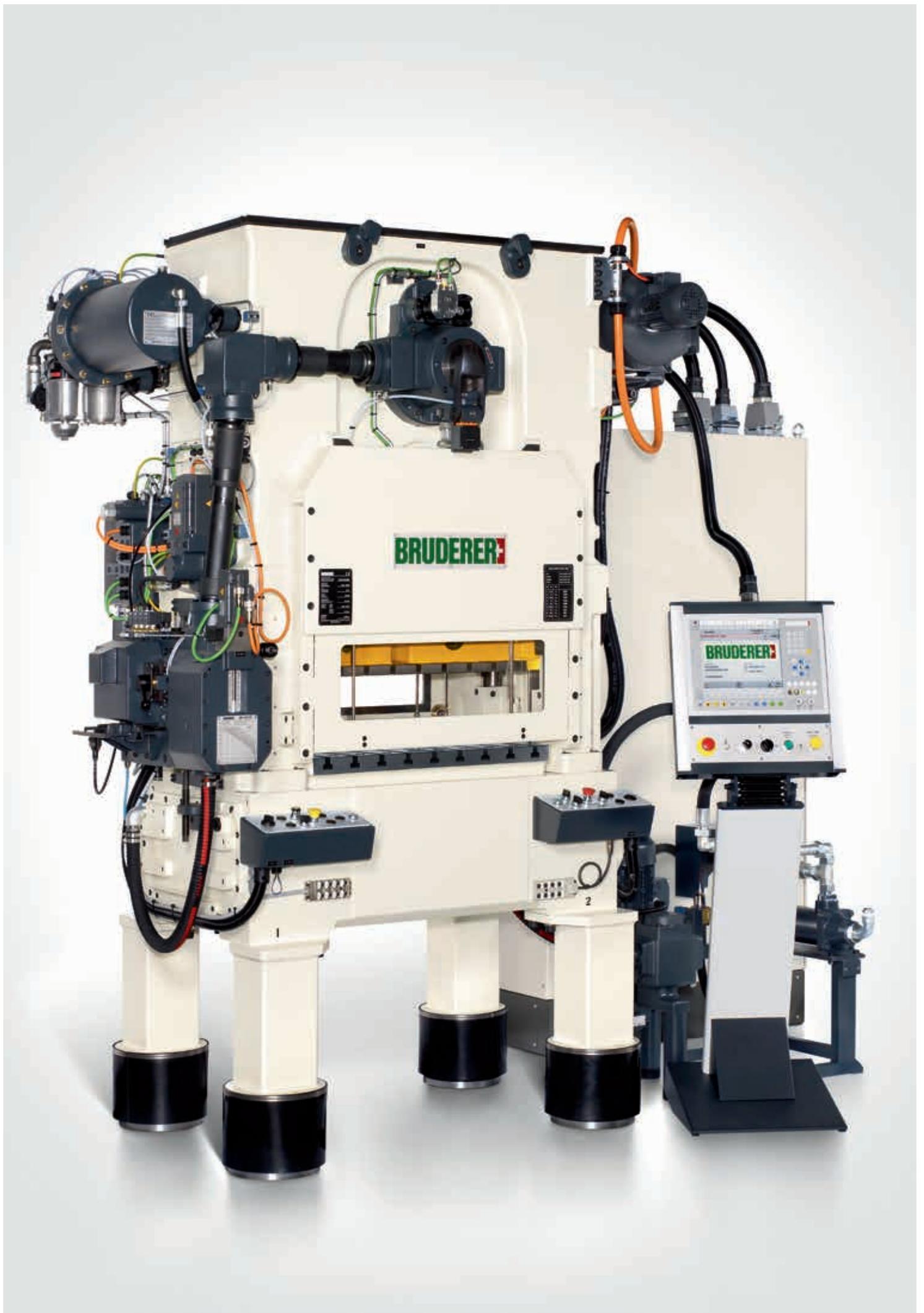
**BSTA 280**

**BRUDERER+**

PRECISION – SWISS MADE

**Innovations and  
experience bringing  
success to your  
products.**





# Our experience – for your benefit.

Every BSTA stamping press contains decades of experience that we have built up, in responding to the demands of ambitious customers.

Important innovations and solutions which pay attention to the little details are designed to help you produce more efficiently using our machines. Try them out for yourself.

## The advantages of the BSTA 280 at a glance.

### **Adjustable stroke with mass balancing system together with latest control technology:**

- for a multitude of applications
- for a wide variety of stroke heights

### **Thermoneutral ram-guiding system with tilting point control at strip level:**

- for long tool life
- for optimum part quality

### **Ram adjustment during operation under production conditions:**

- for an optimized tool set-up

### **Powerful clutch and brake unit**

- for improved first and last strikes and therefore reduced waste

### **Micro-tolerances maintained in the bottom dead center (BDC):**

- for increased process stability

### **Precision engineering and the unique BRUDERER drive and lever system:**

- for improved reliability and durability across the whole mechanical system

### **Integrated measuring and monitoring function:**

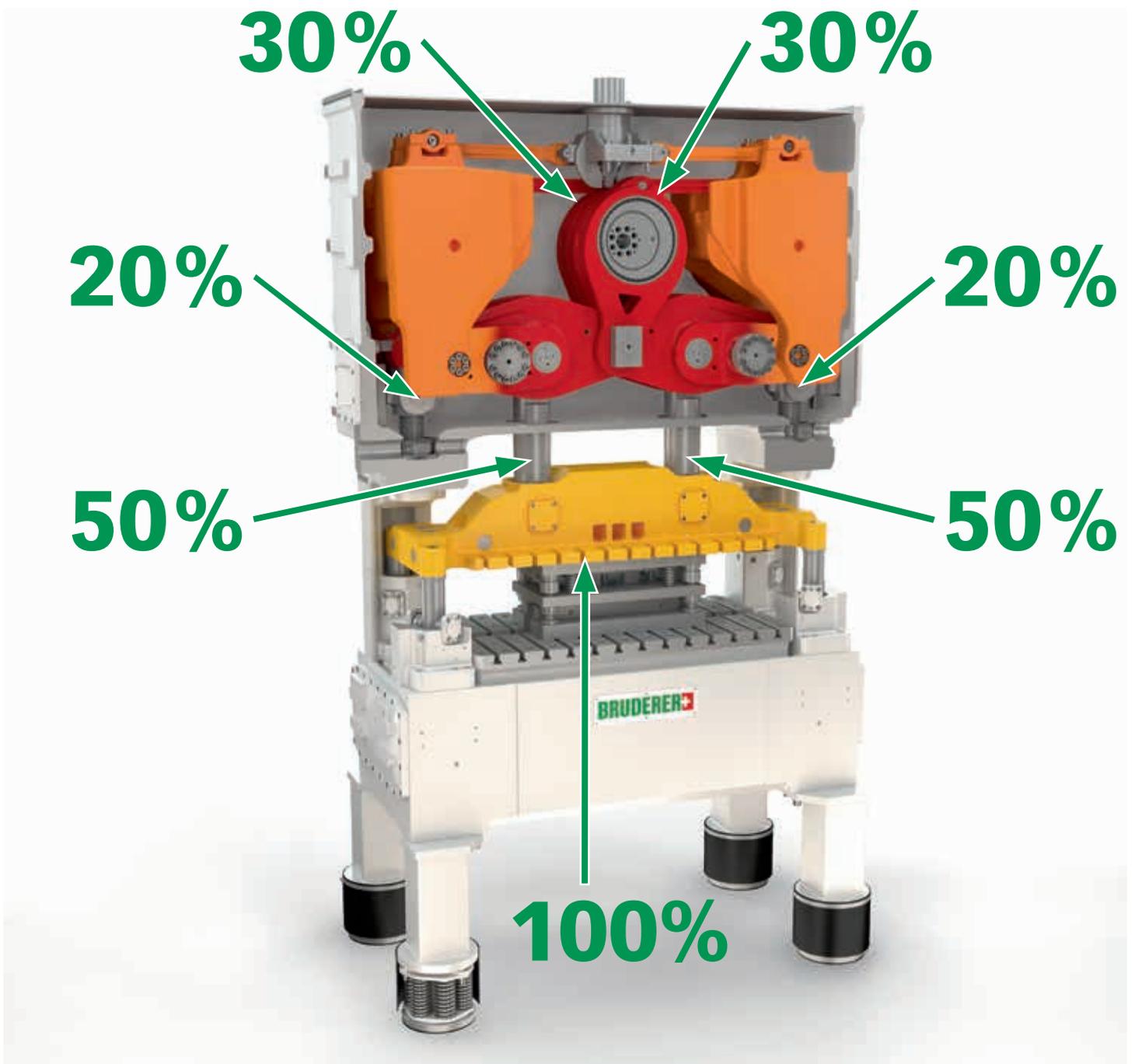
- improved process optimisation by means of simple control system usability

### **Easy attachment of peripheral devices:**

- for quicker integration and maximum productivity

# Power put to work in the right place.

Thanks to the unique lever system of the BSTA stamping press, the load acting on the ram is distributed across the system. This load distribution, together with the absolute minimum clearance and the efficient lubrication system, is a crucial factor in the high durability and consistent precision of the machine.



# Making sure you can produce quicker, for longer and with more precision.

## Regular stamping processes.

Thanks to the unique lever system, the hardened ground ram adjustment spindles only take up 20% of the total load each. This construction makes it possible to adjust the ram height during stamping and to maintain the BDC to the closest of tolerances throughout.

## Longer tool life thanks to good guidance.

To prevent deflection of the punches when running the press with eccentric loads, the ram guide elements are placed exclusively on the same level as the strip. The guide bearings ensure that the thermal influences acting on the ram guides are compensated for, which in turn increase tool life.

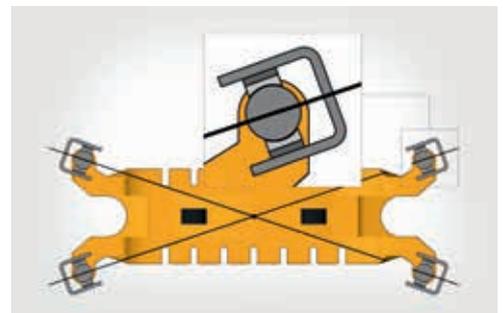
## More flexibility thanks to the right setting.

The quicker stroke change enables different stroke height settings to be set quickly and safely, thus ensuring high levels of flexibility and a wide variety of implementations.

The feed timing of the strip feeder is thus synchronised without additional procedures



Ram adjustment during operation under production conditions.



Thermoneutral ram-guiding to compensate for horizontal expansion due to fluctuations in temperature.



Quicker stroke change for more flexibility.

# Proven solutions.

Leading companies around the world have come to rely on the advantages that BRUDERER fully-automated stamping presses can provide, implementing their manufacturing expertise with our machines to make high-precision parts for products that have become indispensable in our everyday lives.

Wherever the ultimate in availability and precision is required at high and low stroke rates, BRUDERER is there to provide what is needed – for suppliers in the automotive industry, for the manufacturing of connectors for the electronics, electrical engineering and computer industries, for parts for watches and metal packaging for the food industry, to cite just a few examples.

This is how we support our customers, with our expertise and the added precision that our stamping presses provide when it comes to manufacturing quality products.



# Technical data

## BSTA 280.

			BSTA 280 -75	BSTA 280 - 88
Press force		kN	280	280
Tool loading area	L - R	mm	750	880
Speed	Min.	spm	100	100
- Adjustable stroke machine (standard)	Max.	spm	1500	1500
- Adjustable stroke machine <sup>1)</sup>	Max.	spm	2000 <sup>1)</sup>	2000 <sup>1)</sup>
Mains voltage (EN 60204) <sup>A)</sup>		V	400	400
Mains frequency (EN 60204) <sup>A)</sup>		Hz	50 / 60	50 / 60
Connected load <sup>B)</sup>	Max.	kVA	73 / 86 <sup>1)</sup>	73 / 86 <sup>1)</sup>
Control voltage		VDC	24	24
Drive power of main motor		kW	18,5 / 28 <sup>1)</sup>	18,5 / 28 <sup>1)</sup>
Compressed air connection R 1/2"	Min. Max.	bar bar	7 10	7 10
Adjustable stroke (standard)		mm mm	13 / 14 / 16 / 19 / 25 / 32 / 38 / 44 / 47	13 / 14 / 16 / 19 / 25 / 32 / 38 / 44 / 47
Adjustable stroke (option) <sup>1)</sup>		mm mm	6,5 / 8 / 10 / 13 / 16 / 19 / 25 / 35 / 40,5	6,5 / 8 / 10 / 13 / 16 / 19 / 25 / 35 / 40,5
Fixed stroke <sup>A)</sup>	Max.	mm	47	47
Ram adjustment range		mm	51	51
Shut height <sup>A)</sup> (according to stroke)	Min. Max.	mm mm	171 239	171 239
Bolster area	L - R F - B Height <sup>C)</sup>	mm mm mm	740 536 1154	870 536 1154
Ram area	L - R F - B	mm mm	646 360	776 360
Strip inlet height <sup>A)</sup>	Min. Max.	mm mm	50 120	50 120
Strip inlet width (machine)	Max.	mm	230	230
Base plate opening	L - R F - B	mm mm	700 180	830 180
<b>Dimensions</b>				
Press (standard BBV)	L - R	mm	2057	2057
- With semi-automatic stroke adjustment	F - B Height Weight (app.)	mm mm kg	1195 2730 5600	1195 2730 5800
- With automatic stroke adjustment	F - B Height Weight (app.)	mm mm kg	1230 2888 5650	1230 2888 5850
<b>Strip feed unit</b>				
	Standard Variations	BBV 180 BSV 75 BSV 170 BZV 61		

<sup>A)</sup> Options on request. <sup>B)</sup> Incl. standard sockets for peripheral equipment. <sup>C)</sup> Above floor level.

<sup>1)</sup> Adjustable stroke machine with 2000 spm available as option.

Subject to change.

## Competence centres:

### BRUDERER GMBH

Kieferstrasse 28, D - 44225 Dortmund  
☎ +49 231 79 20 22-0, 📠 +49 231 71 91 53  
info.de@bruderer.com

### BRUDERER MACHINERY INC.

1200 Hendricks Causeway, Ridgefield, NJ 07657, USA  
☎ +1 201 941 2121, 📠 +1 201 886 2010  
info@brudereramericas.com

### BRUDERER MACHINERY (SUZHOU) CO., LTD.

No. 485 Suhong Middle Road, Suzhou Industrial Park  
Jiangsu Province, P.R. China 215027  
☎ +86 512 6258 8292, 📠 +86 512 6258 8293  
info.cn@bruderer.com

### BRUDERER PRESSES (FAR EAST) PTE LTD.

65 Loyang Way, Singapore 508755  
☎ +65 6546 8121, 📠 +65 6546 8131  
info.sg@bruderer.com

### BRUDERER PRESSES K.K.

Yakou 2306-2, Sakae-Machi, Inba-Gun, Chiba-Ken Japan 270-1502  
☎ +81 476 801 788, 📠 +81 476 851 277  
info.jp@bruderer.com

### BRUDERER UK LTD.

Cradock Road, GB-Luton, Bedfordshire LU4 0JF  
☎ +44 1582 56 03 00, 📠 +44 1582 57 06 11  
info.uk@bruderer.com

## Sales and service:

### BRUDERER (DONGGUAN) MACHINERY CO., LTD.

Unit E1-22, Changrong International Machinery  
Hardware Business Mansion  
ZhenAn Avenue WuSha Road, ChangAn Town  
Dongguan City, P.R. China 523859  
☎ +86 769 8188 8180, 📠 +86 769 8188 7797  
info.bdg@bruderer.com

### BRUDERER IBERICA, S.L.

Pol. Ind. Magarola Sud, C/. Cerámica 5 - Nave B-1  
E-08292 Esparraguera (Barcelona)  
☎ +34 93 770 84 60, 📠 +34 93 779 51 15  
info.es@bruderer.com

### BRUDERER PRESSES FRANCE S.A.R.L.

Z.I. du Petit Parc, F - 78920 Ecquevilly  
☎ +33 1 34 75 00 40, 📠 +33 1 34 75 52 36  
info.fr@bruderer.com

### BRUDERER PRESSES INDIA PVT LTD.

2, Chandragupta Estate, Ground Floor, Andheri Link Road  
Near Monginis Andheri West, Mumbai 400 053, India  
☎ +91 22 6695 1945/46, 📠 +91 22 6695 1948  
info.in@bruderer.com

## Distribution Partners:

See [www.brunderer.com](http://www.brunderer.com)

### BRUDERER AG

Egnacherstrasse 44, CH-9320 Frasnacht, Switzerland  
☎ +41 71 447 75 00, 📠 +41 71 447 77 80

For more information about BRUDERER and our products,  
services and subsidiaries, visit [www.brunderer.com](http://www.brunderer.com)

**BRUDERER** 

PRECISION – SWISS MADE

**BSTA 410**

**BRUDERER+**

PRECISION – SWISS MADE

**The perfect solution  
for your needs.**





# Our experience – for your benefit.

Every BSTA stamping press contains decades of experience that we have built up, in responding to the demands of ambitious customers.

Important innovations and solutions which pay attention to the little details are designed to help you produce more efficiently using our machines. Try them out for yourself.

## The advantages of the BSTA 410 at a glance.

### **Adjustable stroke with mass balancing system together with latest control technology:**

- for a multitude of applications
- for a wide variety of stroke heights

### **Thermoneutral ram-guiding system with tilting point control at strip level:**

- for long tool life
- for optimum part quality

### **Ram adjustment during operation under production conditions:**

- for an optimized tool set-up

### **Powerful clutch and brake unit**

- for improved first and last strikes and therefore reduced waste

### **Micro-tolerances maintained in the bottom dead center (BDC):**

- for increased process stability

### **Precision engineering and the unique BRUDERER drive and lever system:**

- for improved reliability and durability across the whole mechanical system

### **Integrated measuring and monitoring function:**

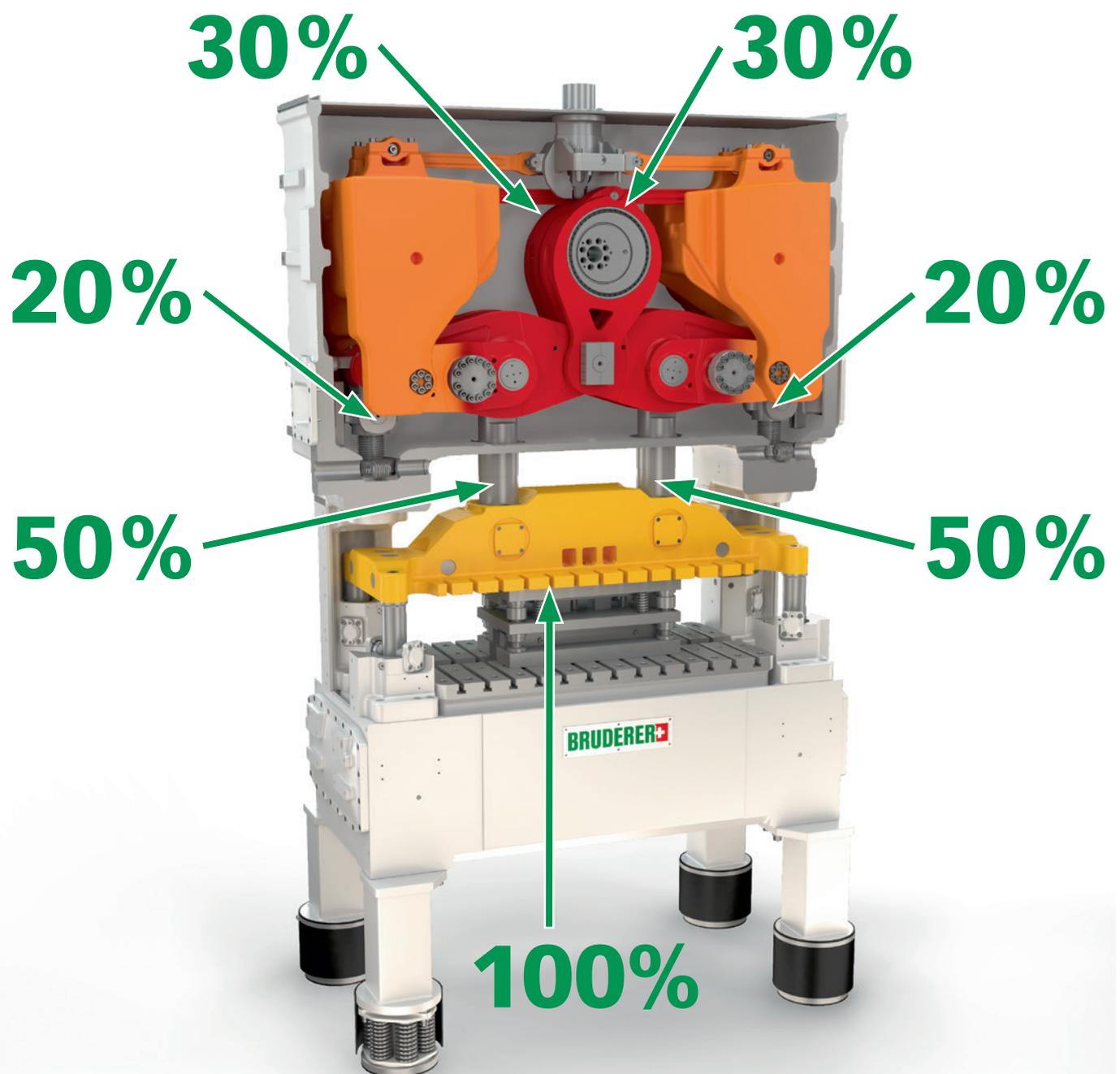
- improved process optimisation by means of simple control system usability

### **Easy attachment of peripheral devices:**

- for quicker integration and maximum productivity

# Power put to work in the right place.

Thanks to the unique lever system of the BSTA stamping press, the load acting on the ram is distributed across the system. This load distribution, together with the absolute minimum clearance and the efficient lubrication system, is a crucial factor in the high durability and consistent precision of the machine.



# Making sure you can produce quicker, for longer and with more precision.

## Regular stamping processes.

Thanks to the unique lever system, the hardened ground ram adjustment spindles only take up 20% of the total load each. This construction makes it possible to adjust the ram height during stamping and to maintain the BDC to the closest of tolerances throughout.

## Longer tool life thanks to good guidance.

To prevent deflection of the punches when running the press with eccentric loads, the ram guide elements are placed exclusively on the same level as the strip. The guide bearings ensure that the thermal influences acting on the ram guides are compensated for, which in turn increase tool life.

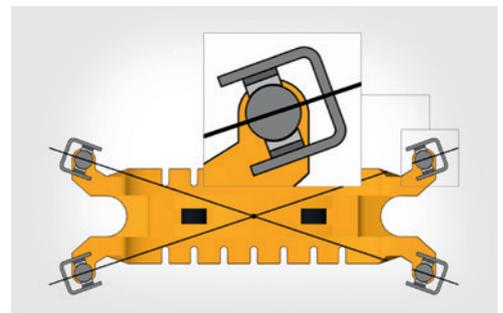
## More flexibility thanks to the right setting.

The quicker stroke change enables different stroke height settings to be set quickly and safely, thus ensuring high levels of flexibility and a wide variety of implementations.

The feed timing of the strip feeder is thus synchronised without additional procedures



Ram adjustment during operation under production conditions.



Thermoneutral ram-guiding to compensate for horizontal expansion due to fluctuations in temperature.



Quicker stroke change for more flexibility.

# Proven solutions.

Leading companies around the world have come to rely on the advantages that BRUDERER fully-automated stamping presses can provide, implementing their manufacturing expertise with our machines to make high-precision parts for products that have become indispensable in our everyday lives.

Wherever the ultimate in availability and precision is required at high and low stroke rates, BRUDERER is there to provide what is needed – for suppliers in the automotive industry, for the manufacturing of connectors for the electronics, electrical engineering and computer industries, for parts for watches and metal packaging for the food industry, to cite just a few examples.

This is how we support our customers, with our expertise and the added precision that our stamping presses provide when it comes to manufacturing quality products.



# Technical data

## BSTA 410.

BSTA 410-110			
Press force		kN	410
Tool loading area	L - R	mm	1100
Speed	Min. Max.	1/min 1/min	100 1600
Mains voltage (EN 60204) <sup>A)</sup>		V	400
Mains frequency (EN 60204) <sup>A)</sup>		Hz	50/60
Connected load <sup>B)</sup>	Max.	kVA	86
Control voltage		VDC	24
Drive power of main motor		kW	28
Compressed air connection R 1/2"	Min. Max.	bar bar	7 10
Adjustable stroke (standard)		mm mm	8 / 13 / 16 / 19 / 25 32 / 38 / 44 / 47
Adjustable stroke (option)		mm mm	16 / 19 / 25 / 32 / 38 44 / 47 / 51 / 57 / 64
Fixed stroke <sup>A)</sup>	Max.	mm	64
Ram adjustment		mm	64
Shut height <sup>A)</sup> (according to stroke)	Min. Max.	mm mm	206 298
Bolster area	L - R F - B Height <sup>C)</sup>	mm mm mm	1080 650 1266
Ram area	L - R F - B	mm mm	980 420
Strip inlet height <sup>A)</sup>	Min. Max.	mm mm	60 140
Strip inlet width (machine)	Max.	mm	250
Base plate opening	L - R F - B	mm mm	1060 200
Dimensions			
Press (standard BBV)	L - R	mm	2369
- With semi-automatic stroke adjustment	F - B Height Weight (app.)	mm mm kg	1255 3200 8700
Strip feed unit			
	Standard	BBV 191	
	Variations	BBV 180 BBV 260 BSV 75 BSV 170 BSV 300 BZV 61	

<sup>A)</sup> Options on request. <sup>B)</sup> Incl. standard sockets for peripheral equipment. <sup>C)</sup> Above floor level. Subject to change.

## Competence centres:

### **BRUDERER GMBH**

Kieferstrasse 28, D - 44225 Dortmund  
☎ +49 231 79 20 22-0, 📠 +49 231 71 91 53  
info.de@bruderer.com

### **BRUDERER MACHINERY INC.**

1200 Hendricks Causeway, Ridgefield, NJ 07657, USA  
☎ +1 201 941 2121, 📠 +1 201 886 2010  
info@brudereramericas.com

### **BRUDERER MACHINERY (SUZHOU) CO., LTD.**

No. 485 Suhong Middle Road, Suzhou Industrial Park  
Jiangsu Province, P.R. China 215027  
☎ +86 512 6258 8292, 📠 +86 512 6258 8293  
info.cn@bruderer.com

### **BRUDERER PRESSES (FAR EAST) PTE LTD.**

65 Loyang Way, Singapore 508755  
☎ +65 6546 8121, 📠 +65 6546 8131  
info.sg@bruderer.com

### **BRUDERER PRESSES K.K.**

Yakou 2306-2, Sakae-Machi, Inba-Gun, Chiba-Ken Japan 270-1502  
☎ +81 476 801 788, 📠 +81 476 851 277  
info.jp@bruderer.com

### **BRUDERER UK LTD.**

Cradock Road, GB-Luton, Bedfordshire LU4 0JF  
☎ +44 1582 56 03 00, 📠 +44 1582 57 06 11  
info.uk@bruderer.com

## Sales and service:

### **BRUDERER (DONGGUAN) MACHINERY CO., LTD.**

Unit E1-22, Changrong International Machinery  
Hardware Business Mansion  
ZhenAn Avenue WuSha Road, ChangAn Town  
Dongguan City, P.R. China 523859  
☎ +86 769 8188 8180, 📠 +86 769 8188 7797  
info.bdg@bruderer.com

### **BRUDERER IBERICA, S.L.**

Pol. Ind. Magarola Sud, C/. Cerámica 5 - Nave B-1  
E-08292 Esparraguera (Barcelona)  
☎ +34 93 770 84 60, 📠 +34 93 779 51 15  
info.es@bruderer.com

### **BRUDERER PRESSES FRANCE S.A.R.L.**

Z.I. du Petit Parc, F - 78920 Ecquevilly  
☎ +33 1 34 75 00 40, 📠 +33 1 34 75 52 36  
info.fr@bruderer.com

### **BRUDERER PRESSES INDIA PVT LTD.**

No. 17 P, Sadaramangala Industrial Area  
White Field Road, Kadugodi  
Bangalore - 560048  
☎ +91 80 2841 1049  
info.in@bruderer.com

## Distribution Partners:

See [www.brunderer.com](http://www.brunderer.com)

### **BRUDERER AG**

Egnacherstrasse 44, CH-9320 Frasnacht, Switzerland  
☎ +41 71 447 75 00, 📠 +41 71 447 77 80

For more information about BRUDERER and our products,  
services and subsidiaries, visit [www.brunderer.com](http://www.brunderer.com)

**BRUDERER** 

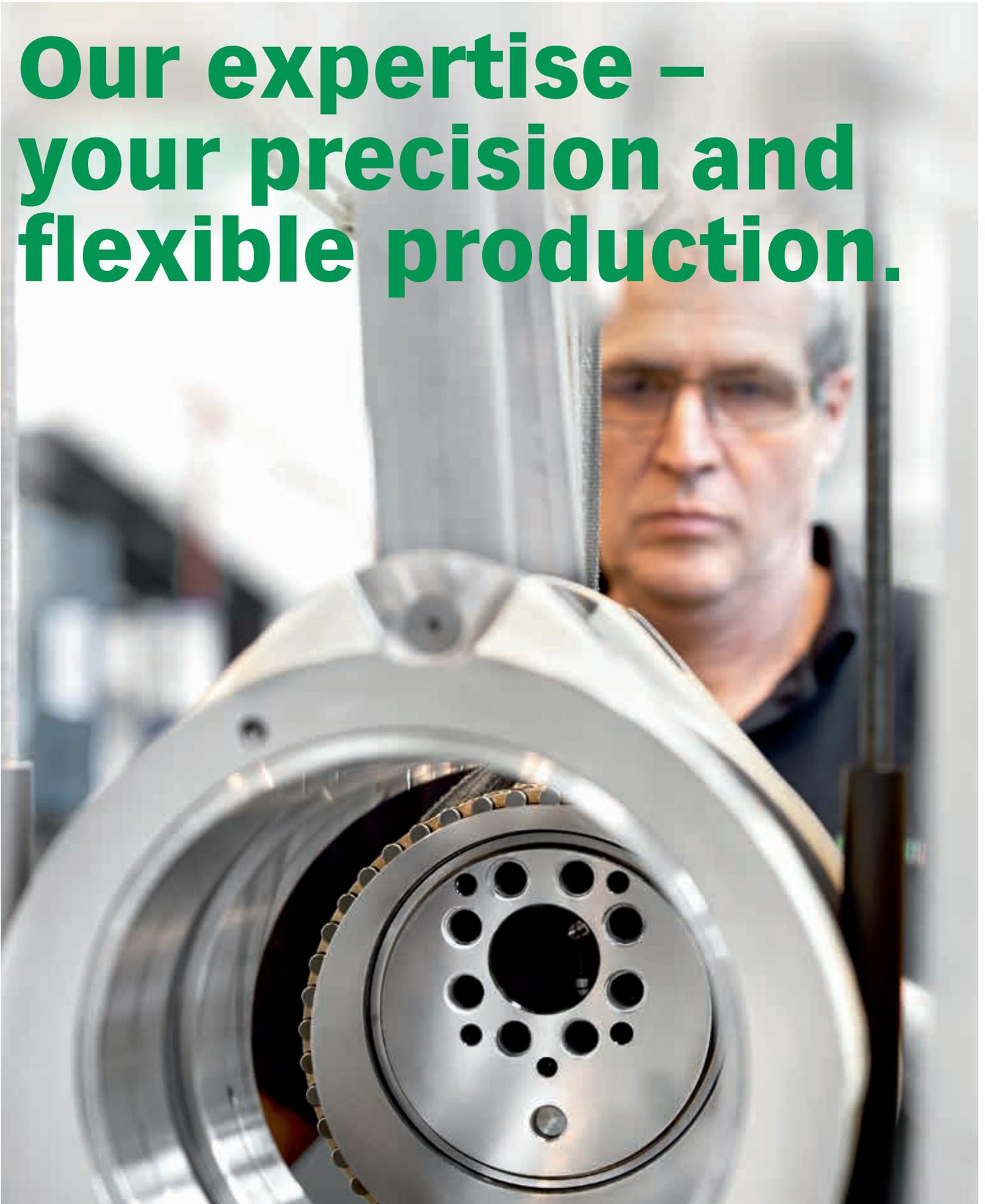
PRECISION – SWISS MADE

**BSTA 510**

**BRUDERER+**

PRECISION – SWISS MADE

**Our expertise –  
your precision and  
flexible production.**





# Our experience – for your benefit.

Every BSTA stamping press contains decades of experience that we have built up, in responding to the demands of ambitious customers.

Important innovations and solutions which pay attention to the little details are designed to help you produce more efficiently using our machines. Try them out for yourself.

## The advantages of the BSTA 510 at a glance.

### **Adjustable stroke with mass balancing system together with latest control technology:**

- for a multitude of applications
- for a wide variety of stroke heights

### **Thermoneutral ram-guiding system with tilting point control at strip level:**

- for long tool life
- for optimum part quality

### **Ram adjustment during operation under production conditions:**

- for an optimized tool set-up

### **Powerful clutch and brake unit**

- for improved first and last strikes and therefore reduced waste

### **Micro-tolerances maintained in the bottom dead center (BDC):**

- for increased process stability

### **Precision engineering and the unique BRUDERER drive and lever system:**

- for improved reliability and durability across the whole mechanical system

### **Integrated measuring and monitoring function:**

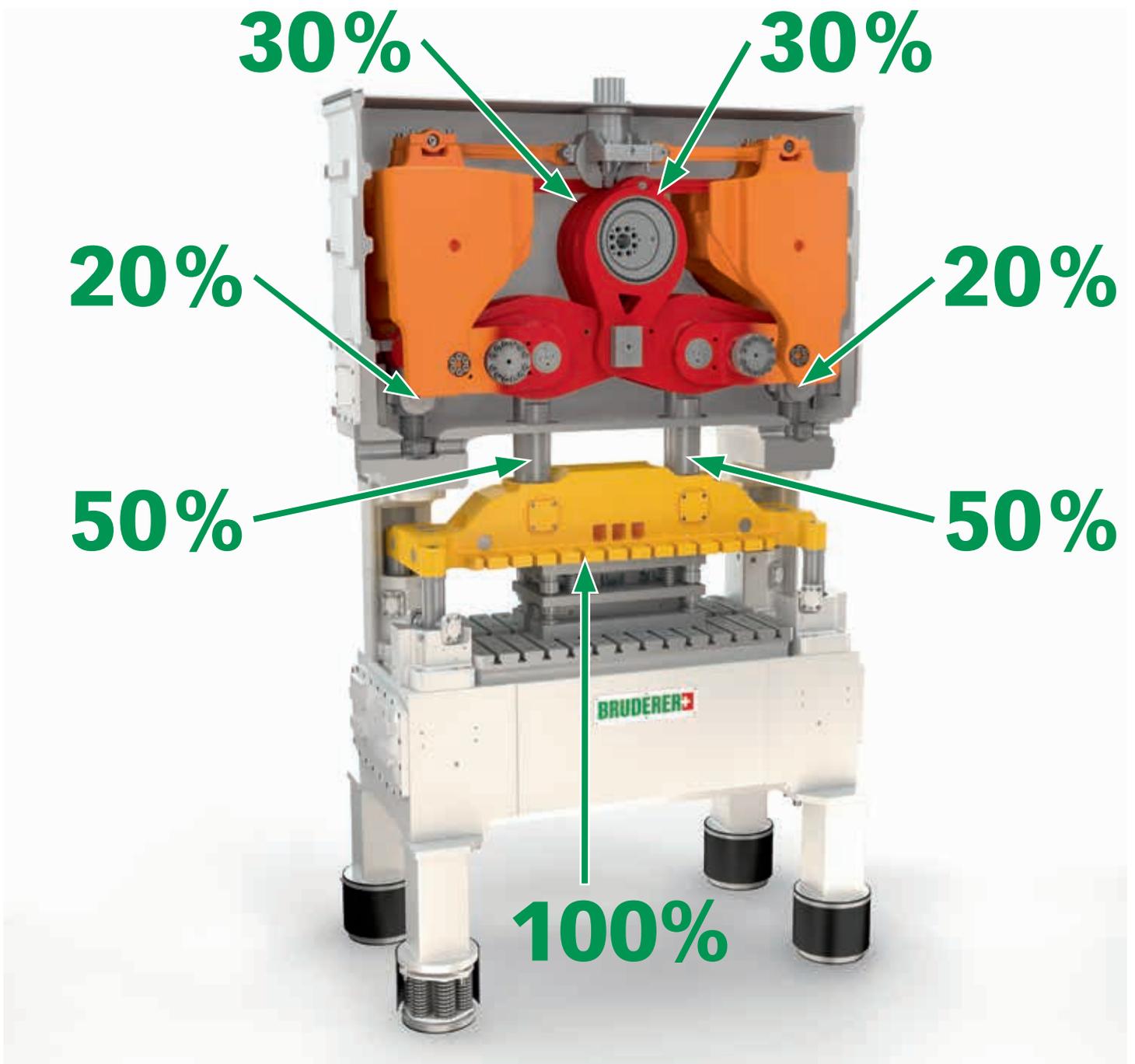
- improved process optimisation by means of simple control system usability

### **Easy attachment of peripheral devices:**

- for quicker integration and maximum productivity

# Power put to work in the right place.

Thanks to the unique lever system of the BSTA stamping press, the load acting on the ram is distributed across the system. This load distribution, together with the absolute minimum clearance and the efficient lubrication system, is a crucial factor in the high durability and consistent precision of the machine.



# Making sure you can produce quicker, for longer and with more precision.

## Regular stamping processes.

Thanks to the unique lever system, the hardened ground ram adjustment spindles only take up 20% of the total load each. This construction makes it possible to adjust the ram height during stamping and to maintain the BDC to the closest of tolerances throughout.

## Longer tool life thanks to good guidance.

To prevent deflection of the punches when running the press with eccentric loads, the ram guide elements are placed exclusively on the same level as the strip. The guide bearings ensure that the thermal influences acting on the ram guides are compensated for, which in turn increase tool life.

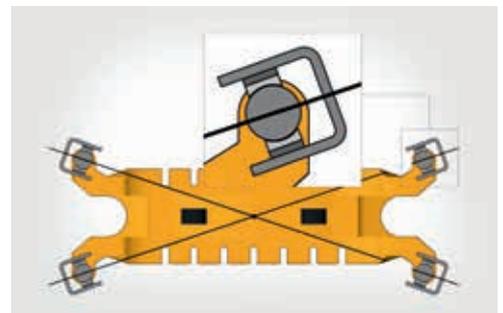
## More flexibility thanks to the right setting.

The quicker stroke change enables different stroke height settings to be set quickly and safely, thus ensuring high levels of flexibility and a wide variety of implementations.

The feed timing of the strip feeder is thus synchronised without additional procedures



Ram adjustment during operation under production conditions.



Thermoneutral ram-guiding to compensate for horizontal expansion due to fluctuations in temperature.



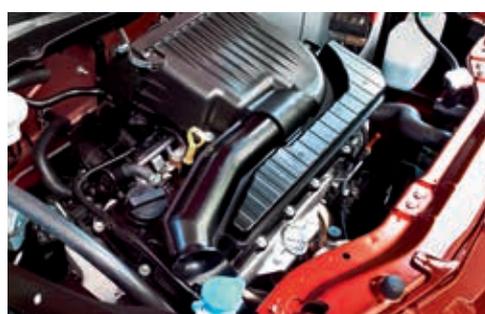
Quicker stroke change for more flexibility.

# Proven solutions.

Leading companies around the world have come to rely on the advantages that BRUDERER fully-automated stamping presses can provide, implementing their manufacturing expertise with our machines to make high-precision parts for products that have become indispensable in our everyday lives.

Wherever the ultimate in availability and precision is required at high and low stroke rates, BRUDERER is there to provide what is needed – for suppliers in the automotive industry, for the manufacturing of connectors for the electronics, electrical engineering and computer industries, for parts for watches and metal packaging for the food industry, to cite just a few examples.

This is how we support our customers, with our expertise and the added precision that our stamping presses provide when it comes to manufacturing quality products.



# Technical data

## BSTA 510.

			BSTA 510-95	BSTA 510-110	BSTA 510-125	BSTA 510-150
Press force		kN	510	510	510	510
Tool loading area	L - R	mm	950	1100	1250	1500
Speed	Min.	spm	100	100	100	100
	Max.	spm	1120	1120	1050	1050
Mains voltage (EN 60204) <sup>A)</sup>		V	400	400	400	400
Mains frequency (EN 60204) <sup>A)</sup>		Hz	50/60	50/60	50/60	50/60
Connected load <sup>B)</sup>	Max.	kVA	80	80	80	80
Control voltage		VDC	24	24	24	24
Drive power of main motor		kW	22	22	22	22
Compressed air connection R 1/2"	Min.	bar	7	7	7	7
	Max.	bar	10	10	10	10
Adjustable stroke (standard)		mm	16 / 19 / 25 / 32 /	16 / 19 / 25 / 32 /	16 / 19 / 25 / 32 /	16 / 19 / 25 / 32 /
		mm	38 / 44 / 51	38 / 44 / 51	38 / 44 / 51	38 / 44 / 51
Adjustable stroke (option)		mm	19 / 25 / 34 / 43 /	19 / 25 / 34 / 43 /	19 / 25 / 34 / 43 /	19 / 25 / 34 / 43 /
		mm	51 / 57 / 64	51 / 57 / 64	51 / 57 / 64	51 / 57 / 64
Fixed stroke <sup>A)</sup>	Max.	mm	64	64	64	64
Ram adjustment		mm	64	64	64	64
Shut height <sup>A)</sup> (according to stroke)	Min.	mm	206	206	206	206
	Max.	mm	294	294	294	294
Bolster area	L - R	mm	940	1080	1240	1490
	F - B	mm	650	650	650	650
	Height <sup>C)</sup>	mm	1221	1266	1266	1250
Ram area	L - R	mm	830	980	1160	1390
	F - B	mm	420	420	420	420
Strip inlet height <sup>A)</sup>	Min.	mm	60	60	60	60
	Max.	mm	140	140	140	140
Strip inlet width (machine)	Max.	mm	250	250	250	250
Base plate opening	L - R	mm	910	1060	1210	1410
	F - B	mm	200	200	200	200
Connectible BPG22 planetary gearbox	Optional		yes	yes	yes	yes
<b>Dimensions</b>						
Press (standard BBV)	L - R	mm	2366	2366	2670	2670
- With semi-automatic stroke adjustment	F - B	mm	1299	1299	1299	1299
	Height	mm	3120	3165	3230	3214
	Weight (app.)	kg	8160	8760	10050	10800
- With automatic stroke adjustment	F - B	mm	1393	1393	1393	1393
	Height	mm	3272	3317	3382	3366
	Weight (app.)	kg	8260	8860	10150	10900
<b>Strip feed unit</b>						
	Standard Variations	BBV 180 BBV 260 BSV 75 BSV 170 BSV 300 BZV 61				

<sup>A)</sup> Options on request. <sup>B)</sup> Incl. standard sockets for peripheral equipment. <sup>C)</sup> Above floor level.  
Subject to change.

## Competence centres:

### **BRUDERER GMBH**

Kieferstrasse 28, D - 44225 Dortmund  
☎ +49 231 79 20 22-0, 📠 +49 231 71 91 53  
info.de@bruderer.com

### **BRUDERER MACHINERY INC.**

1200 Hendricks Causeway, Ridgefield, NJ 07657, USA  
☎ +1 201 941 2121, 📠 +1 201 886 2010  
info@brudereramericas.com

### **BRUDERER MACHINERY (SUZHOU) CO., LTD.**

No. 485 Suhong Middle Road, Suzhou Industrial Park  
Jiangsu Province, P.R. China 215027  
☎ +86 512 6258 8292, 📠 +86 512 6258 8293  
info.cn@bruderer.com

### **BRUDERER PRESSES (FAR EAST) PTE LTD.**

65 Loyang Way, Singapore 508755  
☎ +65 6546 8121, 📠 +65 6546 8131  
info.sg@bruderer.com

### **BRUDERER PRESSES K.K.**

Yakou 2306-2, Sakae-Machi, Inba-Gun, Chiba-Ken Japan 270-1502  
☎ +81 476 801 788, 📠 +81 476 851 277  
info.jp@bruderer.com

### **BRUDERER UK LTD.**

Cradock Road, GB-Luton, Bedfordshire LU4 0JF  
☎ +44 1582 56 03 00, 📠 +44 1582 57 06 11  
info.uk@bruderer.com

## Sales and service:

### **BRUDERER (DONGGUAN) MACHINERY CO., LTD.**

Unit E1-22, Changrong International Machinery  
Hardware Business Mansion  
ZhenAn Avenue WuSha Road, ChangAn Town  
Dongguan City, P.R. China 523859  
☎ +86 769 8188 8180, 📠 +86 769 8188 7797  
info.bdg@bruderer.com

### **BRUDERER IBERICA, S.L.**

Pol. Ind. Magarola Sud, C/. Cerámica 5 - Nave B-1  
E-08292 Esparraguera (Barcelona)  
☎ +34 93 770 84 60, 📠 +34 93 779 51 15  
info.es@bruderer.com

### **BRUDERER PRESSES FRANCE S.A.R.L.**

Z.I. du Petit Parc, F - 78920 Ecquevilly  
☎ +33 1 34 75 00 40, 📠 +33 1 34 75 52 36  
info.fr@bruderer.com

### **BRUDERER PRESSES INDIA PVT LTD.**

2, Chandragupta Estate, Ground Floor, Andheri Link Road  
Near Monginis Andheri West, Mumbai 400 053, India  
☎ +91 22 6695 1945/46, 📠 +91 22 6695 1948  
info.in@bruderer.com

## Distribution Partners:

See [www.brunderer.com](http://www.brunderer.com)

### **BRUDERER AG**

Egnacherstrasse 44, CH-9320 Frasnacht, Switzerland  
☎ +41 71 447 75 00, 📠 +41 71 447 77 80

For more information about BRUDERER and our products,  
services and subsidiaries, visit [www.brunderer.com](http://www.brunderer.com)

**BRUDERER** 

PRECISION – SWISS MADE

**BSTA 810**

**BRUDERER+**

PRECISION – SWISS MADE

**Durable and  
accurate – the fruits  
of our experience.**





# Our experience – for your benefit.

Every BSTA stamping press contains decades of experience that we have built up, in responding to the demands of ambitious customers.

Important innovations and solutions which pay attention to the little details are designed to help you produce more efficiently using our machines. Try them out for yourself.

## The advantages of the BSTA 810 at a glance.

### **Adjustable stroke with mass balancing system together with latest control technology:**

- for a multitude of applications
- for a wide variety of stroke heights

### **Thermoneutral ram-guiding system with tilting point control at strip level:**

- for long tool life
- for optimum part quality

### **Ram adjustment during operation under production conditions:**

- for an optimized tool set-up

### **Powerful clutch and brake unit**

- for improved first and last strikes and therefore reduced waste

### **Micro-tolerances maintained in the bottom dead center (BDC):**

- for increased process stability

### **Precision engineering and the unique BRUDERER drive and lever system:**

- for improved reliability and durability across the whole mechanical system

### **Integrated measuring and monitoring function:**

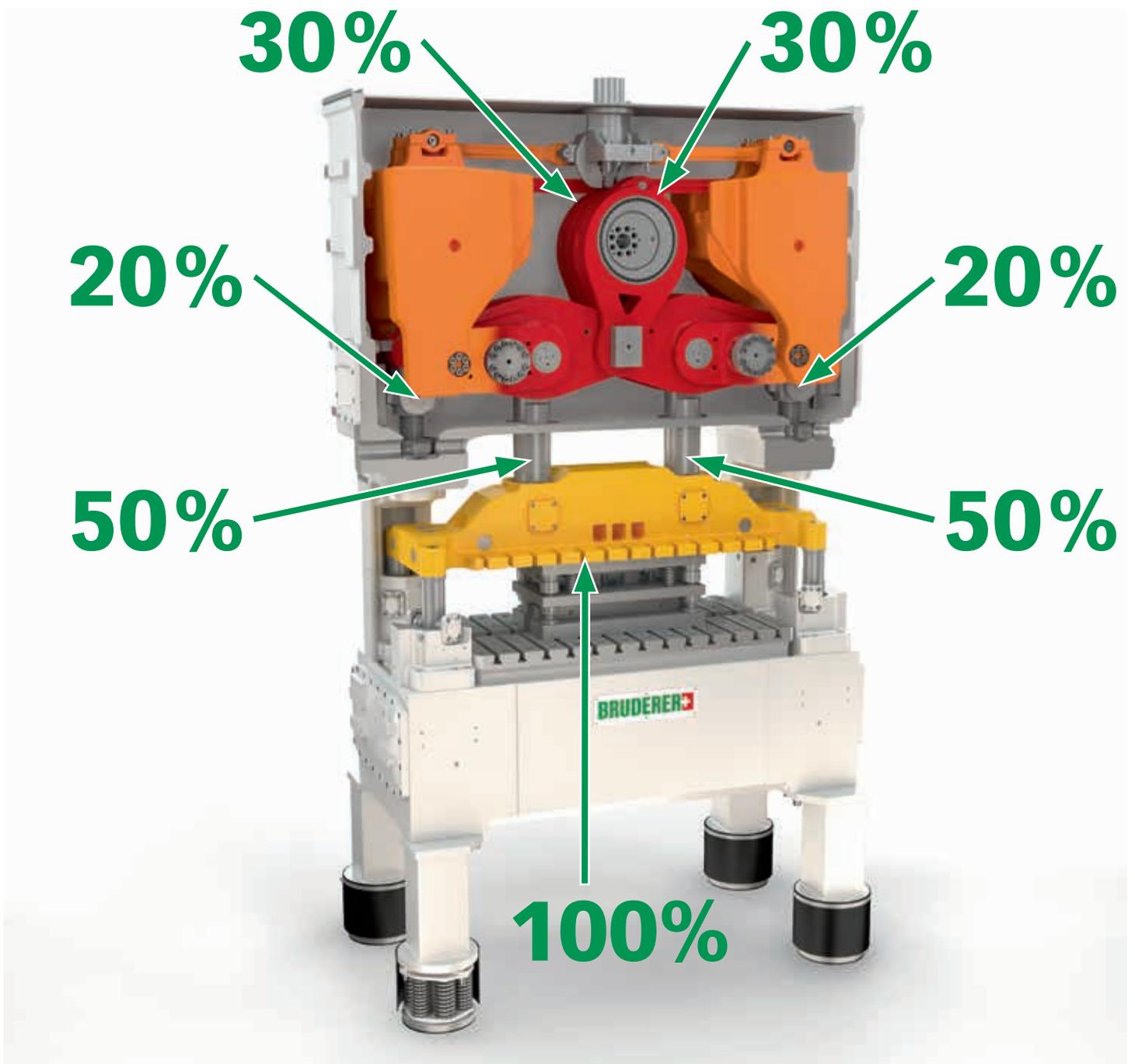
- improved process optimisation by means of simple control system usability

### **Easy attachment of peripheral devices:**

- for quicker integration and maximum productivity

# Power put to work in the right place.

Thanks to the unique lever system of the BSTA stamping press, the load acting on the ram is distributed across the system. This load distribution, together with the absolute minimum clearance and the efficient lubrication system, is a crucial factor in the high durability and consistent precision of the machine.



# Making sure you can produce quicker, for longer and with more precision.

## Regular stamping processes.

Thanks to the unique lever system, the hardened ground ram adjustment spindles only take up 20% of the total load each. This construction makes it possible to adjust the ram height during stamping and to maintain the BDC to the closest of tolerances throughout.

## Longer tool life thanks to good guidance.

To prevent deflection of the punches when running the press with eccentric loads, the ram guide elements are placed exclusively on the same level as the strip. The guide bearings ensure that the thermal influences acting on the ram guides are compensated for, which in turn increase tool life.

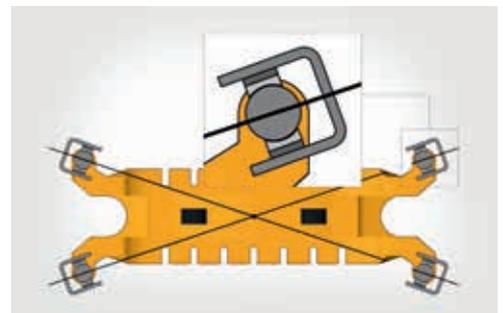
## More flexibility thanks to the right setting.

The quicker stroke change enables different stroke height settings to be set quickly and safely, thus ensuring high levels of flexibility and a wide variety of implementations.

The feed timing of the strip feeder is thus synchronised without additional procedures



Ram adjustment during operation under production conditions.



Thermoneutral ram-guiding to compensate for horizontal expansion due to fluctuations in temperature.



Quicker stroke change for more flexibility.

# Proven solutions.

Leading companies around the world have come to rely on the advantages that BRUDERER fully-automated stamping presses can provide, implementing their manufacturing expertise with our machines to make high-precision parts for products that have become indispensable in our everyday lives.

Wherever the ultimate in availability and precision is required at high and low stroke rates, BRUDERER is there to provide what is needed – for suppliers in the automotive industry, for the manufacturing of connectors for the electronics, electrical engineering and computer industries, for parts for watches and metal packaging for the food industry, to cite just a few examples.

This is how we support our customers, with our expertise and the added precision that our stamping presses provide when it comes to manufacturing quality products.



# Technical data

## BSTA 810.

			BSTA 810-124	BSTA 810-145	BSTA 810-180
Press force		kN	810	810	810
Tool loading area	L - R	mm	1240	1450	1800
Speed	Min.	spm	100	100	100
	Max.	spm	1000	1000	950
Mains voltage (EN 60204) <sup>A)</sup>		V	400	400	400
Mains frequency (EN 60204) <sup>A)</sup>		Hz	50/60	50/60	50/60
Connected load <sup>B)</sup>	Max.	kVA	105	105	105
Control voltage		VDC	24	24	24
Drive power of main motor		kW	37	37	37
Compressed air connection R 1/2"	Min.	bar	7	7	7
	Max.	bar	10	10	10
Adjustable stroke (standard)		mm	16/19/26/35/	16/19/26/35/	16/19/26/35/
		mm	43/51/58/63	43/51/58/63	43/51/58/63
Adjustable stroke (option)		mm	19/26/36/47/	19/26/36/47/	19/26/36/47/
		mm	57/66/73/82	57/66/73/82	57/66/73/82
Fixed stroke <sup>A)</sup>	Max.	mm	82	82	82
Ram adjustment		mm	76	76	76
Shut height <sup>A)</sup> (according to stroke)	Min.	mm	240,5	240,5	240,5
	Max.	mm	340	340	340
Bolster area	L - R	mm	1220	1430	1790
	F - B	mm	910	910	910
	Height <sup>C)</sup>	mm	1245	1295	1295
Ram area	L - R	mm	1060	1270	1630
	F - B	mm	510	510	510
Strip inlet height <sup>A)</sup>	Min.	mm	70	70	70
	Max.	mm	160	160	160
Strip inlet width (machine)	Max.	mm	380	380	380
Base plate opening	L - R	mm	1190	1400	1760
	F - B	mm	320	250	250
<b>Dimensions</b>					
Press (standard BBV)	L - R	mm	2857	2980	3468
- With semi-automatic stroke adjustment	F - B	mm	1648	1648	1648
	Height	mm	3560	3610	3708
	Weight (app.)	kg	18000	18950	23300
- With automatic stroke adjustment	F - B	mm	1717	1717	1717
	Height	mm	3671	3721	3819
	Weight (app.)	kg	18100	19050	23400
<b>Strip feed unit</b>					
	Standard Variations	BBV 260 BSV 170 BSV 300			

<sup>A)</sup> Options on request. <sup>B)</sup> Incl. standard sockets for peripheral equipment. <sup>C)</sup> Above floor level.  
Subject to change.

## Competence centres:

### BRUDERER GMBH

Kieferstrasse 28, D - 44225 Dortmund  
☎ +49 231 79 20 22-0, 📠 +49 231 71 91 53  
info.de@bruderer.com

### BRUDERER MACHINERY INC.

1200 Hendricks Causeway, Ridgefield, NJ 07657, USA  
☎ +1 201 941 2121, 📠 +1 201 886 2010  
info@brudereramericas.com

### BRUDERER MACHINERY (SUZHOU) CO., LTD.

No. 485 Suhong Middle Road, Suzhou Industrial Park  
Jiangsu Province, P.R. China 215027  
☎ +86 512 6258 8292, 📠 +86 512 6258 8293  
info.cn@bruderer.com

### BRUDERER PRESSES (FAR EAST) PTE LTD.

65 Loyang Way, Singapore 508755  
☎ +65 6546 8121, 📠 +65 6546 8131  
info.sg@bruderer.com

### BRUDERER PRESSES K.K.

Yakou 2306-2, Sakae-Machi, Inba-Gun, Chiba-Ken Japan 270-1502  
☎ +81 476 801 788, 📠 +81 476 851 277  
info.jp@bruderer.com

### BRUDERER UK LTD.

Cradock Road, GB-Luton, Bedfordshire LU4 0JF  
☎ +44 1582 56 03 00, 📠 +44 1582 57 06 11  
info.uk@bruderer.com

## Sales and service:

### BRUDERER (DONGGUAN) MACHINERY CO., LTD.

Unit E1-22, Changrong International Machinery  
Hardware Business Mansion  
ZhenAn Avenue WuSha Road, ChangAn Town  
Dongguan City, P.R. China 523859  
☎ +86 769 8188 8180, 📠 +86 769 8188 7797  
info.bdg@bruderer.com

### BRUDERER IBERICA, S.L.

Pol. Ind. Magarola Sud, C/. Cerámica 5 - Nave B-1  
E-08292 Esparraguera (Barcelona)  
☎ +34 93 770 84 60, 📠 +34 93 779 51 15  
info.es@bruderer.com

### BRUDERER PRESSES FRANCE S.A.R.L.

Z.I. du Petit Parc, F - 78920 Ecquevilly  
☎ +33 1 34 75 00 40, 📠 +33 1 34 75 52 36  
info.fr@bruderer.com

### BRUDERER PRESSES INDIA PVT LTD.

2, Chandragupta Estate, Ground Floor, Andheri Link Road  
Near Monginis Andheri West, Mumbai 400 053, India  
☎ +91 22 6695 1945/46, 📠 +91 22 6695 1948  
info.in@bruderer.com

## Distribution Partners:

See [www.brunderer.com](http://www.brunderer.com)

### BRUDERER AG

Egnacherstrasse 44, CH-9320 Frasnacht, Switzerland  
☎ +41 71 447 75 00, 📠 +41 71 447 77 80

For more information about BRUDERER and our products,  
services and subsidiaries, visit [www.brunderer.com](http://www.brunderer.com)

**BRUDERER** 

PRECISION – SWISS MADE

**BSTA 1250**

**BRUDERER+**

PRECISION – SWISS MADE

**Precision strength  
for major tasks.**





# Our experience – for your benefit.

Every BSTA stamping press contains decades of experience that we have built up, in responding to the demands of ambitious customers.

Important innovations and solutions which pay attention to the little details are designed to help you produce more efficiently using our machines. Try them out for yourself.

## The advantages of the BSTA 1250 at a glance.

### **Adjustable stroke with mass balancing system together with latest control technology:**

- for a multitude of applications
- for a wide variety of stroke heights

### **Thermoneutral ram-guiding system with tilting point control at strip level:**

- for long tool life
- for optimum part quality

### **Ram adjustment during operation under production conditions:**

- for an optimized tool set-up

### **Powerful clutch and brake unit**

- for improved first and last strikes and therefore reduced waste

### **Micro-tolerances maintained in the bottom dead center (BDC):**

- for increased process stability

### **Precision engineering and the unique BRUDERER drive and lever system:**

- for improved reliability and durability across the whole mechanical system

### **Integrated measuring and monitoring function:**

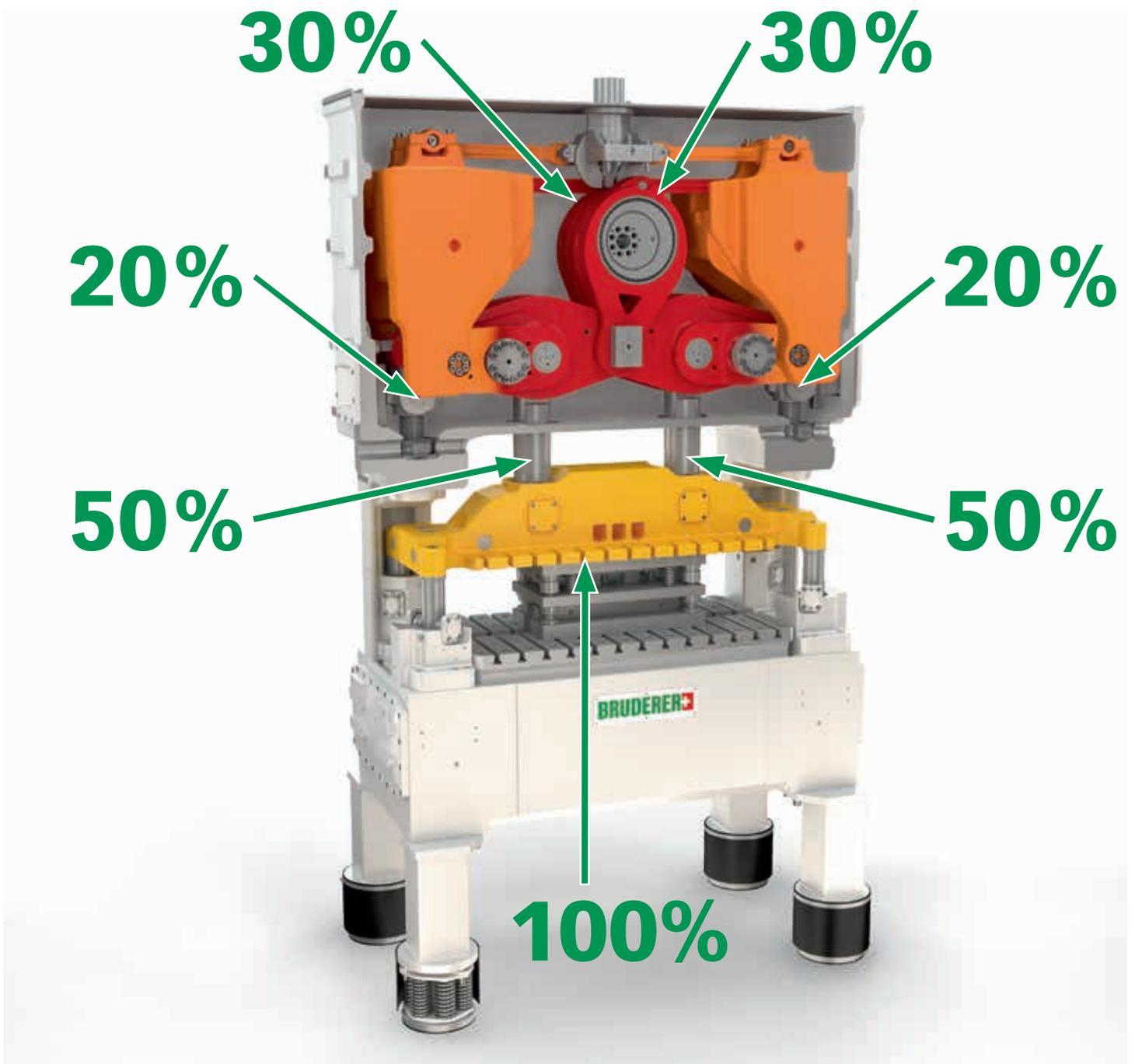
- improved process optimisation by means of simple control system usability

### **Easy attachment of peripheral devices:**

- for quicker integration and maximum productivity

# Power put to work in the right place.

Thanks to the unique lever system of the BSTA stamping press, the load acting on the ram is distributed across the system. This load distribution, together with the absolute minimum clearance and the efficient lubrication system, is a crucial factor in the high durability and consistent precision of the machine.



# Making sure you can produce quicker, for longer and with more precision.

## Regular stamping processes.

Thanks to the unique lever system, the hardened ground ram adjustment spindles only take up 20% of the total load each. This construction makes it possible to adjust the ram height during stamping and to maintain the BDC to the closest of tolerances throughout.

## Longer tool life thanks to good guidance.

To prevent deflection of the punches when running the press with eccentric loads, the ram guide elements are placed exclusively on the same level as the strip. The guide bearings ensure that the thermal influences acting on the ram guides are compensated for, which in turn increase tool life.

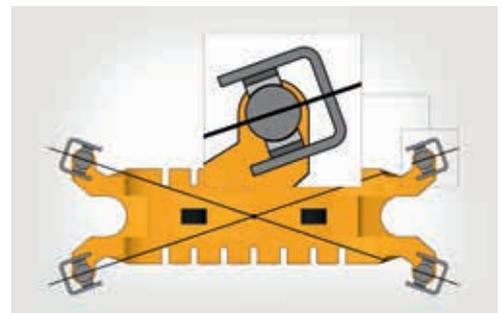
## More flexibility thanks to the right setting.

The quicker stroke change enables different stroke height settings to be set quickly and safely, thus ensuring high levels of flexibility and a wide variety of implementations.

The feed timing of the strip feeder is thus synchronised without additional procedures



Ram adjustment during operation under production conditions.



Thermoneutral ram-guiding to compensate for horizontal expansion due to fluctuations in temperature.



Quicker stroke change for more flexibility.

# Proven solutions.

Leading companies around the world have come to rely on the advantages that BRUDERER fully-automated stamping presses can provide, implementing their manufacturing expertise with our machines to make high-precision parts for products that have become indispensable in our everyday lives.

Wherever the ultimate in availability and precision is required at high and low stroke rates, BRUDERER is there to provide what is needed – for suppliers in the automotive industry, for the manufacturing of connectors for the electronics, electrical engineering and computer industries, for parts for watches and metal packaging for the food industry, to cite just a few examples.

This is how we support our customers, with our expertise and the added precision that our stamping presses provide when it comes to manufacturing quality products.



# Technical data

## BSTA 1250.

			BSTA 1250-117	BSTA 1250-151	BSTA 1250-181
Press force		kN	1250	1250	1250
Tool loading area	L - R	mm	1170	1510	1810
Speed	Min.	spm	100	100	100
	Max.	spm	850	850	850
Mains voltage (EN 60204) <sup>A)</sup>		V	400	400	400
Mains frequency (EN 60204) <sup>A)</sup>		Hz	50/60	50/60	50/60
Connected load <sup>B)</sup>	Max.	kVA	105	105	105
Control voltage		VDC	24	24	24
Drive power of main motor		kW	37	37	37
Compressed air connection R 1/2"	Min.	bar	7	7	7
	Max.	bar	10	10	10
Adjustable stroke (standard)		mm	16/19/26/35/43/	16/19/26/35/43/	16/19/26/35/43/
		mm	51/58/64/70/75	51/58/64/70/75	51/58/64/70/75
Adjustable stroke (option)		mm	19/26/40/55/68/	19/26/40/55/68/	19/26/40/55/68/
		mm	80/90/96/100	80/90/96/100	80/90/96/100
Fixed stroke <sup>A)</sup>	Max.	mm	100	100	100
Ram adjustment range		mm	89	89	89
Shut height <sup>A)</sup> (according to stroke)	Min.	mm	268	268	268
	Max.	mm	386,5	386,5	386,5
Bolster area	L - R	mm	1150	1490	1790
	F - B	mm	1070	1070	1070
	Height <sup>C)</sup>	mm	1245	1270	1270
Ram area	L - R	mm	1060	1400	1700
	F - B	mm	600	600	600
Strip inlet height <sup>A)</sup>	Min.	mm	80	80	80
	Max.	mm	180	180	180
Strip inlet width (machine)	Max.	mm	440	440	440
Base plate opening	L - R	mm	1120	1460	1760
	F - B	mm	350	350	350
<b>Dimensions</b>					
Press (standard BBV)	L - R	mm	2970	3246	3469
- With semi-automatic stroke adjustment	F - B	mm	1818	1818	1818
	Height	mm	4015	4040	4040
	Weight (app.)	kg	25550	27950	29750
- With automatic stroke adjustment	F - B	mm	1887	1887	1887
	Height	mm	4146	4171	4171
	Weight (app.)	kg	25650	28050	29850
<b>Strip feed unit</b>					
	Standard Variations	BBV 260 BBV 450 BBV 455 BSV 300 BSV 500			

<sup>A)</sup> Options on request. <sup>B)</sup> Incl. standard sockets for peripheral equipment. <sup>C)</sup> Above floor level.  
Subject to change.

## Competence centres:

### BRUDERER GMBH

Kieferstrasse 28, D - 44225 Dortmund  
☎ +49 231 79 20 22-0, 📠 +49 231 71 91 53  
info.de@bruderer.com

### BRUDERER MACHINERY INC.

1200 Hendricks Causeway, Ridgefield, NJ 07657, USA  
☎ +1 201 941 2121, 📠 +1 201 886 2010  
info@brudereramericas.com

### BRUDERER MACHINERY (SUZHOU) CO., LTD.

No. 485 Suhong Middle Road, Suzhou Industrial Park  
Jiangsu Province, P.R. China 215027  
☎ +86 512 6258 8292, 📠 +86 512 6258 8293  
info.cn@bruderer.com

### BRUDERER PRESSES (FAR EAST) PTE LTD.

65 Loyang Way, Singapore 508755  
☎ +65 6546 8121, 📠 +65 6546 8131  
info.sg@bruderer.com

### BRUDERER PRESSES K.K.

Yakou 2306-2, Sakae-Machi, Inba-Gun, Chiba-Ken Japan 270-1502  
☎ +81 476 801 788, 📠 +81 476 851 277  
info.jp@bruderer.com

### BRUDERER UK LTD.

Cradock Road, GB-Luton, Bedfordshire LU4 0JF  
☎ +44 1582 56 03 00, 📠 +44 1582 57 06 11  
info.uk@bruderer.com

## Sales and service:

### BRUDERER (DONGGUAN) MACHINERY CO., LTD.

Unit E1-22, Changrong International Machinery  
Hardware Business Mansion  
ZhenAn Avenue WuSha Road, ChangAn Town  
Dongguan City, P.R. China 523859  
☎ +86 769 8188 8180, 📠 +86 769 8188 7797  
info.bdg@bruderer.com

### BRUDERER IBERICA, S.L.

Pol. Ind. Magarola Sud, C/. Cerámica 5 - Nave B-1  
E-08292 Esparraguera (Barcelona)  
☎ +34 93 770 84 60, 📠 +34 93 779 51 15  
info.es@bruderer.com

### BRUDERER PRESSES FRANCE S.A.R.L.

Z.I. du Petit Parc, F - 78920 Ecquevilly  
☎ +33 1 34 75 00 40, 📠 +33 1 34 75 52 36  
info.fr@bruderer.com

### BRUDERER PRESSES INDIA PVT LTD.

2, Chandragupta Estate, Ground Floor, Andheri Link Road  
Near Monginis Andheri West, Mumbai 400 053, India  
☎ +91 22 6695 1945/46, 📠 +91 22 6695 1948  
info.in@bruderer.com

## Distribution Partners:

See [www.brunderer.com](http://www.brunderer.com)

### BRUDERER AG

Egnacherstrasse 44, CH-9320 Frasnacht, Switzerland  
☎ +41 71 447 75 00, 📠 +41 71 447 77 80

For more information about BRUDERER and our products,  
services and subsidiaries, visit [www.brunderer.com](http://www.brunderer.com)

**BRUDERER** 

PRECISION – SWISS MADE

**BSTA 1600**

**BRUDERER+**

PRECISION – SWISS MADE

**The power behind  
your efficient  
production.**





# Our experience – for your benefit.

Every BSTA stamping press contains decades of experience that we have built up, in responding to the demands of ambitious customers.

Important innovations and solutions which pay attention to the little details are designed to help you produce more efficiently using our machines. Try them out for yourself.

## The advantages of the BSTA 1600 at a glance.

### **Adjustable stroke with mass balancing system together with latest control technology:**

- for a multitude of applications
- for a wide variety of stroke heights

### **Thermoneutral ram-guiding system with tilting point control at strip level:**

- for long tool life
- for optimum part quality

### **Ram adjustment during operation under production conditions:**

- for an optimized tool set-up

### **Powerful clutch and brake unit**

- for improved first and last strikes and therefore reduced waste

### **Micro-tolerances maintained in the bottom dead center (BDC):**

- for increased process stability

### **Precision engineering and the unique BRUDERER drive and lever system:**

- for improved reliability and durability across the whole mechanical system

### **Integrated measuring and monitoring function:**

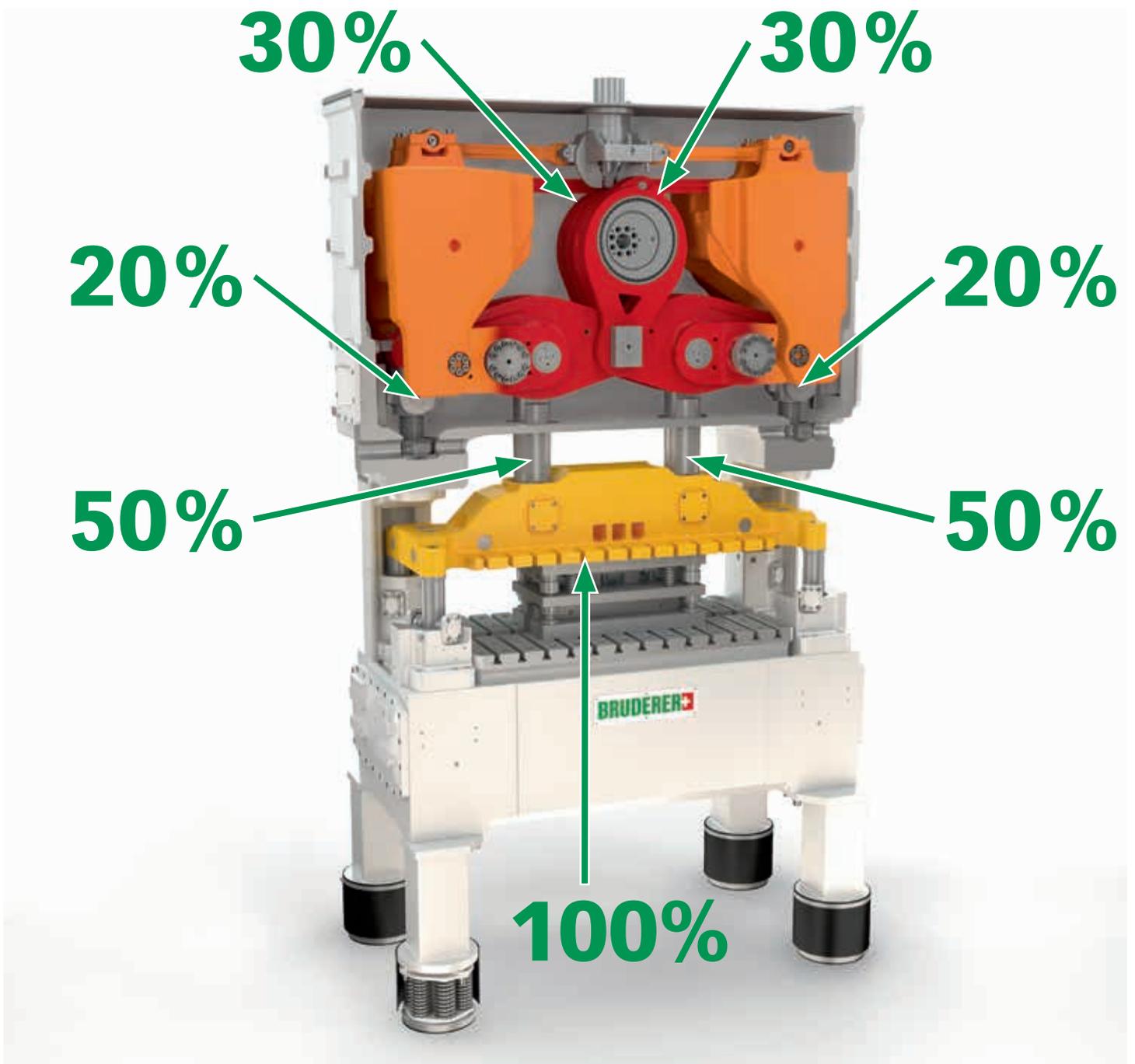
- improved process optimisation by means of simple control system usability

### **Easy attachment of peripheral devices:**

- for quicker integration and maximum productivity

# Power put to work in the right place.

Thanks to the unique lever system of the BSTA stamping press, the load acting on the ram is distributed across the system. This load distribution, together with the absolute minimum clearance and the efficient lubrication system, is a crucial factor in the high durability and consistent precision of the machine.



# Making sure you can produce quicker, for longer and with more precision.

## Regular stamping processes.

Thanks to the unique lever system, the hardened ground ram adjustment spindles only take up 20% of the total load each. This construction makes it possible to adjust the ram height during stamping and to maintain the BDC to the closest of tolerances throughout.

## Longer tool life thanks to good guidance.

To prevent deflection of the punches when running the press with eccentric loads, the ram guide elements are placed exclusively on the same level as the strip. The guide bearings ensure that the thermal influences acting on the ram guides are compensated for, which in turn increase tool life.

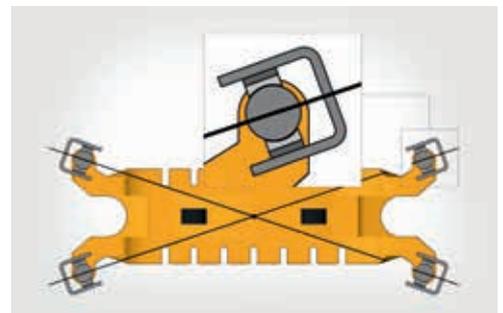
## More flexibility thanks to the right setting.

The quicker stroke change enables different stroke height settings to be set quickly and safely, thus ensuring high levels of flexibility and a wide variety of implementations.

The feed timing of the strip feeder is thus synchronised without additional procedures



Ram adjustment during operation under production conditions.



Thermoneutral ram-guiding to compensate for horizontal expansion due to fluctuations in temperature.



Quicker stroke change for more flexibility.

# Proven solutions.

Leading companies around the world have come to rely on the advantages that BRUDERER fully-automated stamping presses can provide, implementing their manufacturing expertise with our machines to make high-precision parts for products that have become indispensable in our everyday lives.

Wherever the ultimate in availability and precision is required at high and low stroke rates, BRUDERER is there to provide what is needed – for suppliers in the automotive industry, for the manufacturing of connectors for the electronics, electrical engineering and computer industries, for parts for watches and metal packaging for the food industry, to cite just a few examples.

This is how we support our customers, with our expertise and the added precision that our stamping presses provide when it comes to manufacturing quality products.



# Technical data

## BSTA 1600.

			BSTA 1600-117	BSTA 1600-151	BSTA 1600-181	BSTA 1600-220
Press force		kN	1600	1600	1600	1600
Tool loading area	L - R	mm	1170	1510	1810	2200
Speed	Min.	spm	100	100	100	100
	Max.	spm	825	800	800	760
Mains voltage (EN 60204) <sup>A)</sup>		V	400	400	400	400
Mains frequency (EN 60204) <sup>A)</sup>		Hz	50/60	50/60	50/60	50/60
Connected load <sup>B)</sup>	Max.	kVA	132	132	132	132
Control voltage		VDC	24	24	24	24
Drive power of main motor		kW	50	50	50	50
Compressed air connection R 1/2"	Min.	bar	7	7	7	7
	Max.	bar	10	10	10	10
Adjustable stroke (standard)		mm mm	19/25/34/43/ 52/60/67/75	19/25/34/43/ 52/60/67/75	19/25/34/43/ 52/60/67/75	19/25/34/43/ 52/60/67/75
Adjustable stroke (option)		mm mm	19/26/40/55/68/ 80/90/96/100	19/26/40/55/68/ 80/90/96/100	19/26/40/55/68/ 80/90/96/100	19/26/40/55/68/ 80/90/96/100
Fixed stroke <sup>A)</sup>	Max.	mm	100	100	100	100
Ram adjustment range		mm	89	89	89	89
Shut height <sup>A)</sup> (according to stroke)	Min.	mm	268	268	268	268
	Max.	mm	385	385	385	385
Bolster area	L - R	mm	1150	1490	1790	2200
	F - B	mm	1070	1070	1070	1070
	Height <sup>C)</sup>	mm	1245	1270	1270	1270
Ram area	L - R	mm	1060	1400	1700	2100
	F - B	mm	600	600	600	600
Strip inlet height <sup>A)</sup>	Min.	mm	80	80	80	80
	Max.	mm	180	180	180	180
Strip inlet width (machine)	Max.	mm	440	440	440	440
Base plate opening	L - R	mm	1120	1460	1760	2160
	F - B	mm	350	350	350	350
<b>Dimensions</b>						
Press (standard BBV)	L - R	mm	2958	3234	3469	3972
- With semi-automatic stroke adjustment	F - B	mm	1818	1818	1818	1818
	Height	mm	4025	4050	4050	4150
	Weight (app.)	kg	25950	28350	30150	35550
- With automatic stroke adjustment	F - B	mm	1887	1887	1887	1887
	Height	mm	4146	4171	4171	4171
	Weight (app.)	kg	26050	28450	30250	35650
<b>Strip feed unit</b>						
	Standard Variations	BBV 260 BBV 450 BBV 455 BSV 300 BSV 500				

<sup>A)</sup> Options on request. <sup>B)</sup> Incl. standard sockets for peripheral equipment. <sup>C)</sup> Above floor level.  
Subject to change.

## Competence centres:

### BRUDERER GMBH

Kieferstrasse 28, D - 44225 Dortmund  
☎ +49 231 79 20 22-0, 📠 +49 231 71 91 53  
info.de@bruderer.com

### BRUDERER MACHINERY INC.

1200 Hendricks Causeway, Ridgefield, NJ 07657, USA  
☎ +1 201 941 2121, 📠 +1 201 886 2010  
info@brudereramericas.com

### BRUDERER MACHINERY (SUZHOU) CO., LTD.

No. 485 Suhong Middle Road, Suzhou Industrial Park  
Jiangsu Province, P.R. China 215027  
☎ +86 512 6258 8292, 📠 +86 512 6258 8293  
info.cn@bruderer.com

### BRUDERER PRESSES (FAR EAST) PTE LTD.

65 Loyang Way, Singapore 508755  
☎ +65 6546 8121, 📠 +65 6546 8131  
info.sg@bruderer.com

### BRUDERER PRESSES K.K.

Yakou 2306-2, Sakae-Machi, Inba-Gun, Chiba-Ken Japan 270-1502  
☎ +81 476 801 788, 📠 +81 476 851 277  
info.jp@bruderer.com

### BRUDERER UK LTD.

Cradock Road, GB-Luton, Bedfordshire LU4 0JF  
☎ +44 1582 56 03 00, 📠 +44 1582 57 06 11  
info.uk@bruderer.com

## Sales and service:

### BRUDERER (DONGGUAN) MACHINERY CO., LTD.

Unit E1-22, Changrong International Machinery  
Hardware Business Mansion  
ZhenAn Avenue WuSha Road, ChangAn Town  
Dongguan City, P.R. China 523859  
☎ +86 769 8188 8180, 📠 +86 769 8188 7797  
info.bdg@bruderer.com

### BRUDERER IBERICA, S.L.

Pol. Ind. Magarola Sud, C/. Cerámica 5 - Nave B-1  
E-08292 Esparraguera (Barcelona)  
☎ +34 93 770 84 60, 📠 +34 93 779 51 15  
info.es@bruderer.com

### BRUDERER PRESSES FRANCE S.A.R.L.

Z.I. du Petit Parc, F - 78920 Ecquevilly  
☎ +33 1 34 75 00 40, 📠 +33 1 34 75 52 36  
info.fr@bruderer.com

### BRUDERER PRESSES INDIA PVT LTD.

2, Chandragupta Estate, Ground Floor, Andheri Link Road  
Near Monginis Andheri West, Mumbai 400 053, India  
☎ +91 22 6695 1945/46, 📠 +91 22 6695 1948  
info.in@bruderer.com

## Distribution Partners:

See [www.brunderer.com](http://www.brunderer.com)

### BRUDERER AG

Egnacherstrasse 44, CH-9320 Frasnacht, Switzerland  
☎ +41 71 447 75 00, 📠 +41 71 447 77 80

For more information about BRUDERER and our products,  
services and subsidiaries, visit [www.brunderer.com](http://www.brunderer.com)

**BRUDERER** 

PRECISION – SWISS MADE